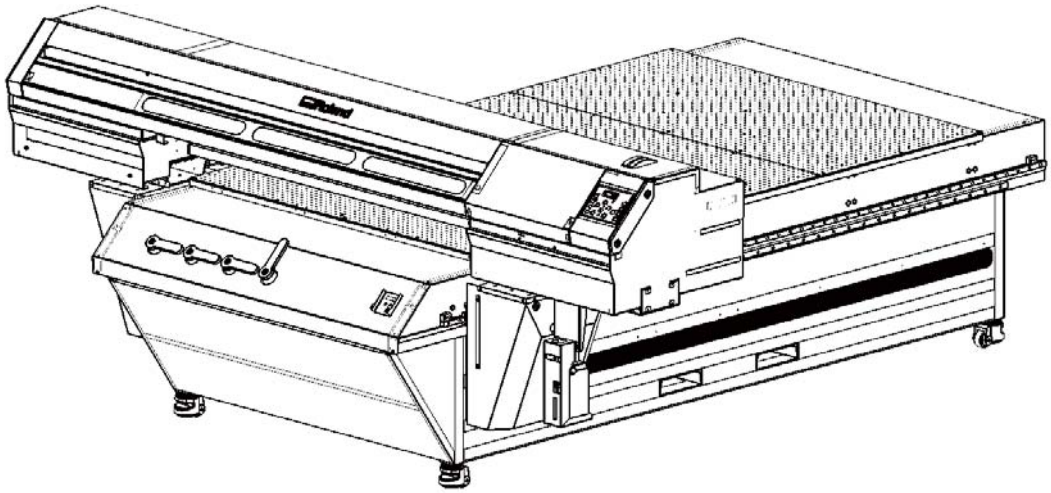
Roland

UV LED PRINTER VersaUV

LEJ-640FT

User's Manual



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Roland DG Corp. has licensed the MMP technology from the TPL Group.

For the USA

FEDERAL COMMUNICATIONS COMMISSION RADIO FREQUENCY INTERFERENCE STATEMENT

NOTE: This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of the FCC Rules.
These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment.
This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications.
Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his own expense.

Unauthorized changes or modification to this system can void the users authority to operate this equipment.

Use only I/O cables that have been designed and manufactured specifically for this device.

For Canada

NOTICE

This Class A digital apparatus meets all requirements of the Canadian Interference-Causing Equipment Regulations.

AVIS

Cet appareil numérique de la classe A respecte toutes les exigences du Règlement sur le matériel brouilleur du Canada.

For California

WARNING

This product contains chemicals known to cause cancer, birth defects and other reproductive harm.

For EU Countries

WARNING

This is a Class A product. In a domestic environment this product may cause radio interference in which case the user may be required to take adequate measures.

NOTICE

Grounding Instructions

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn out cord immediately.

Operating Instructions

KEEP WORK AREA CLEAN. Cluttered areas and benches invites accidents.

DON'T USE IN DANGEROUS ENVIRONMENT. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.

DISCONNECT TOOLS before servicing; when changing accessories, such as blades, bits, cutters, and like.

REDUCE THE RISK OF UNINTENTIONAL STARTING. Make sure the switch is in off position before plugging in.

USE RECOMMENDED ACCESSORIES. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.

NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. Don't leave tool until it comes to a complete stop.

For EU Countries

CE

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For China

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部件名称	有毒有害物质或元素					
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印刷电路板	×	○	×	○	○	○
头部	×	○	○	○	○	○
壳体、底架	×	○	○	○	○	○
电源	×	○	×	○	○	○
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所谓环保使用期限是指在自制造日起的规定期限内，产品中所含的有害物质不致引起环境污染，不会对人身、财产造成严重的不良影响。
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不当的使用，将会导致有害物质泄漏的危险。

For EU Countries

This product must be disposed of separately at your local waste recycling center. Do not dispose of in household waste bin.

Bitte führen Sie dieses Produkt separat Ihrer örtlichen Entsorgungsstelle zu. Bitte nicht mit dem normalen Hausmüll entsorgen.

Ne jetez pas le produit avec vos ordures ménagères. Portez-le dans un centre recyclage des déchets.

Questo prodotto deve essere smaltito negli appositi contenitori per la raccolta differenziata, non buttare nel cestino dei rifiuti casalinghi.

Este producto debe devolverse al centro de reciclaje más cercano a su domicilio para su correcta eliminación. No lo tire a la basura.

Deite fora separadamente este produto no seu centro de reciclagem local. Não o deite fora no seu caixote do lixo.

Lever dit product in bij een lokaal afvalverzamelpunt. NIET met normaal huishoudelijk afval afvoeren.

Dette Produkt skal smides særskilt væk på den lokale affalds- og genbrugsstation. Må ikke smides ud sammen med almindeligt husholdningsaffald.

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Part Names and Functions

Printer Unit

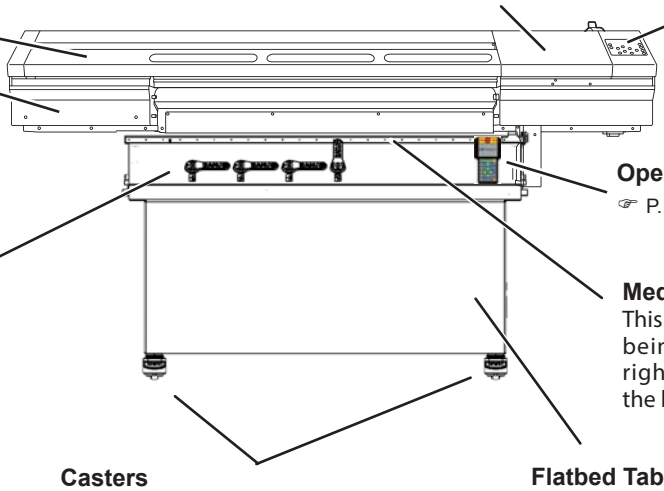
Front

Front cover 1
Be sure to close this when users perform printing.

Side cover
Users remove this when performing maintenance.

Operation panel
☞ P. 9, "Operation Panel"

Maintenance cover
Users remove this when performing cleaning of the print heads.



Operation Keypad
☞ P. 11, "Keypad Panel"

Vacuum Valves
Turn on/off vacuum table zones manually

Media guide
This positions the media being used to the 0/0 right front position of the bed.

Casters
Allows for easy moving during installation

Flatbed Table
For use when users are using firm, rigid media.

Rear

Status LED
This flashes yellow while data is being received from the network.

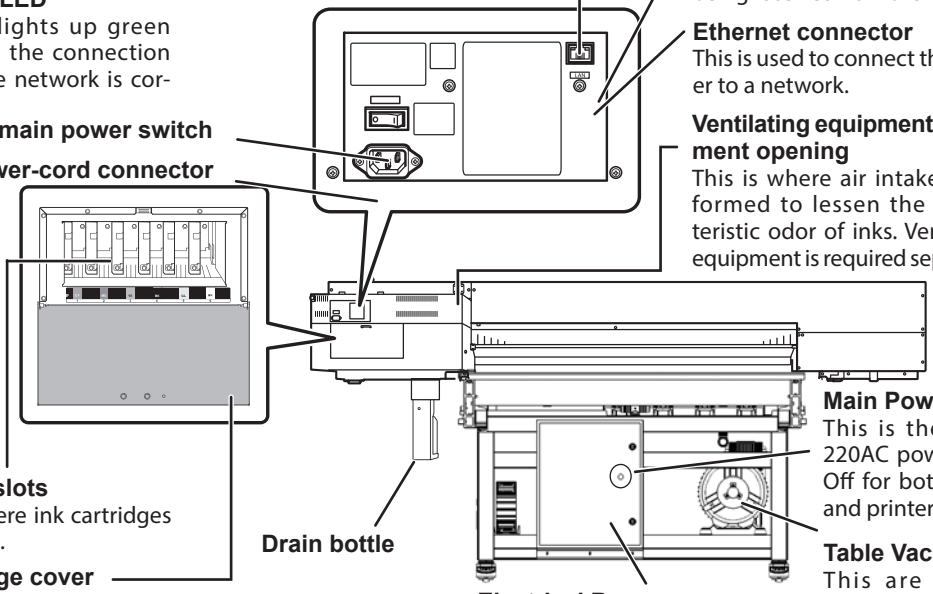
Link LED
This lights up green when the connection to the network is cor-

Ethernet connector
This is used to connect the printer to a network.

Printer main power switch

Power-cord connector

Ventilating equipment attachment opening
This is where air intake is performed to lessen the characteristic odor of inks. Ventilating equipment is required separately.



Main Power
This is the main 220AC power On/Off for both table and printer

Cartridge slots
This are where ink cartridges are installed.

Drain bottle

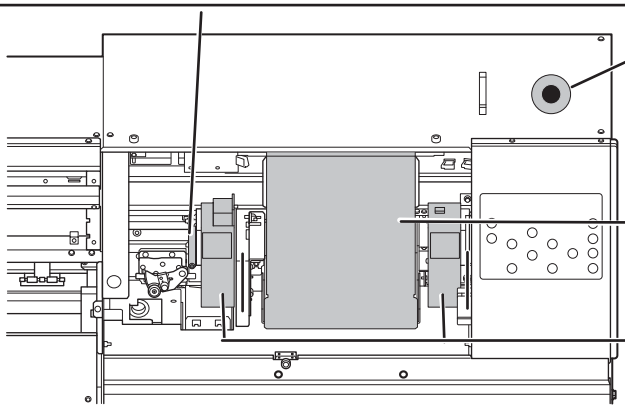
Table Vacuum
This are where vacuum filters are to be replaced

Ink cartridge cover
Close this cover except when absolutely necessary, such as when users are replacing ink cartridges.

Electrical Box
Authorized Service Technician or Licensed Electrician Only

Print Head Periphery

Laser Pointer
Points to a position on the media.



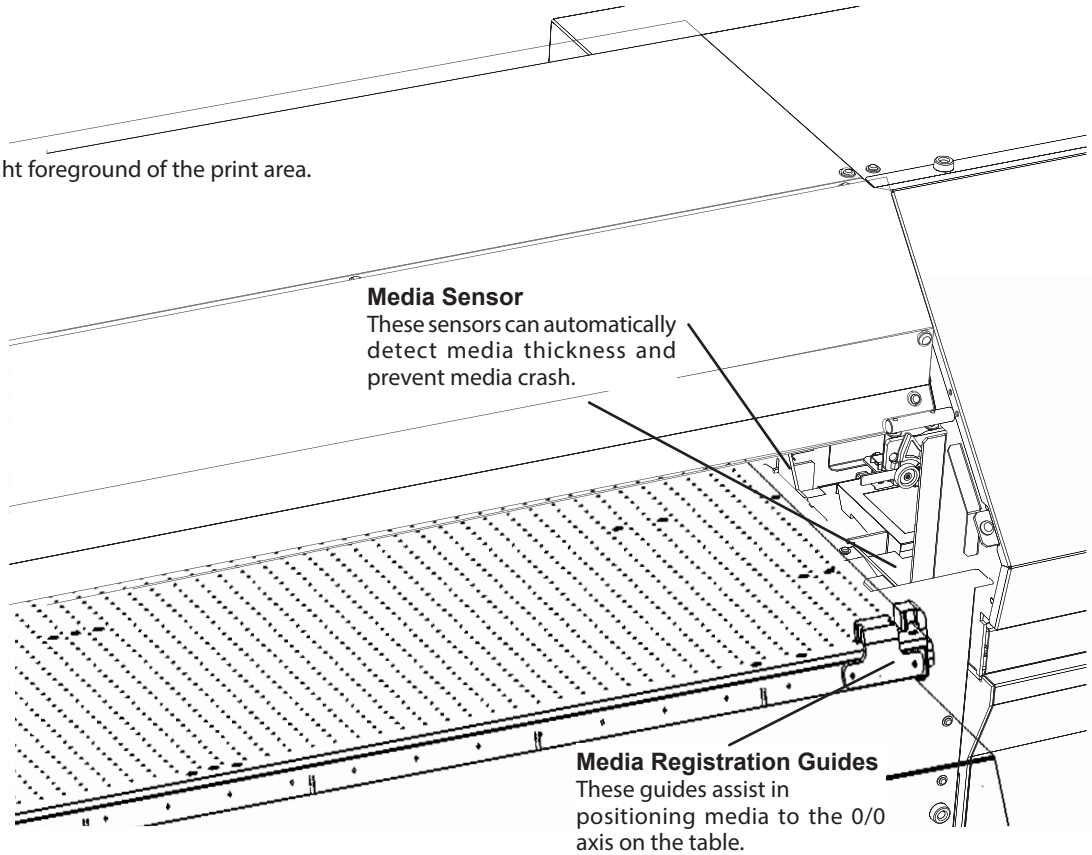
Emergency Stop
One of three emergency stop buttons immediately shutting off print activity. (Two on top of the printer and one on the hand-held Keypad

Print-head carriage
The print heads are inside this.

UV emitter
These are the ultraviolet (UV) LEDs. They emit light only during printing.

Front Cover 1 Inside

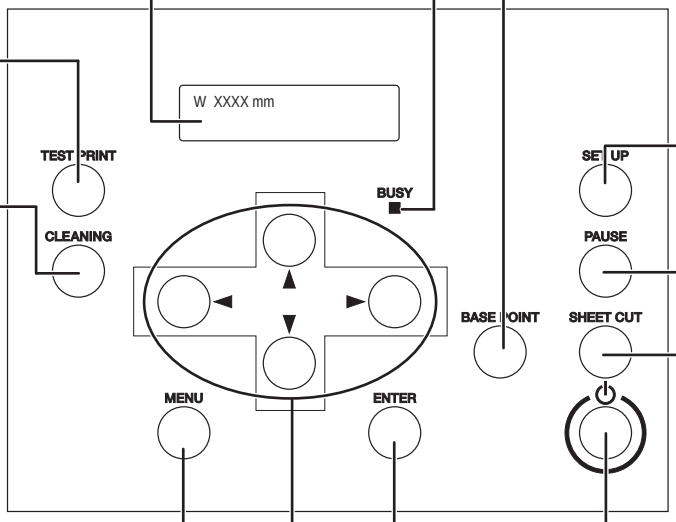
right foreground of the print area.



Media Sensor
These sensors can automatically detect media thickness and prevent media crash.

Media Registration Guides
These guides assist in positioning media to the 0/0 axis on the table.

Operation Panel



Display screen
This displays various setting menus and other information.

BUSY light
This lights up during printing and other such operations.

BASE POINT key
Users use this when wanting to set the output-start location. This lights up when the setting has been made.

TEST PRINT key
Holding this down for one second or longer performs a printing test.

SETUP key
Users press this when loading media. This lights up when media is loaded and the machine is ready to perform output.

CLEANING key
Users use this to perform cleaning of the print heads.

PAUSE key
This pauses the output operation. This lights up when operation is paused.

SHEET CUT key
Active, but NOT functional.

ENTER key
Users use this for such tasks as enabling setting

Sub power switch
This switches the printer on and off. (To switch the printer off, users hold down the switch for one second or longer.) This flashes slowly when the machine is in the sleep

Cursor keys
Users use these to select settings for menu items, to move the media, and for other such operations.

MENU key
Users press this to enter the menus for various settings.

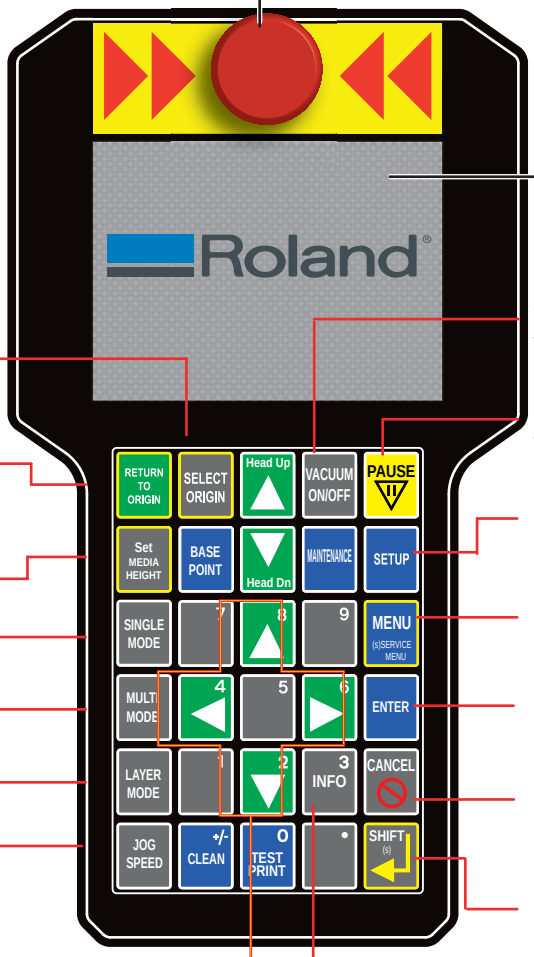
Panel Notation

In this document, the keys and lights on the operation panel are indicated by the following images.

MENU **MENU key**
SET UP **SETUP key**
ENTER **ENTER key**
▲ ▼ ◄ ► **Cursor keys**
PAUSE **PAUSE key**
CLEANING **CLEANING key**
TEST PRINT **TEST PRINT key**
BASE POINT **BASE POINT key**
SHEET CUT **SHEET CUT key**

Keypad Panel

Emergency Stop
(E-Stop) button cuts power to everything except the control board of the unit, which will go into Emergency Stop mode.



Keypad Monitor
This displays various setting menus and other information.

SELECT ORIGIN
Allows users to Set specific origins for printing.

Return to Origin
Returns printer to Home position.

Set Media Height
Sets media height either automatically or manually.

Print Modes
Changes operation Modes for printing.

JOG Speed
Changes the movement speed for controlled accuracy.

Cursor keys
Controls printer and print head movement.

Vacuum
This maintains uniform tension for media.

Pause
This pauses the output operation.

SETUP
Users press this when loading media.

MENU
Users press this to enter the menus for various settings.

ENTER
Users use this for such tasks as enabling setting values.

CANCEL
Cancels certain funtions and cancels printing.

SHIFT
Activiates additional Keypad functions. More on Page 12.

INFO
This maintains uniform tension for media.

Yellow
Items indicate an action with Shift.

Green Buttons
Items indicate a movement on printer.

Grey Buttons
Items indicate a specific function of the Table.

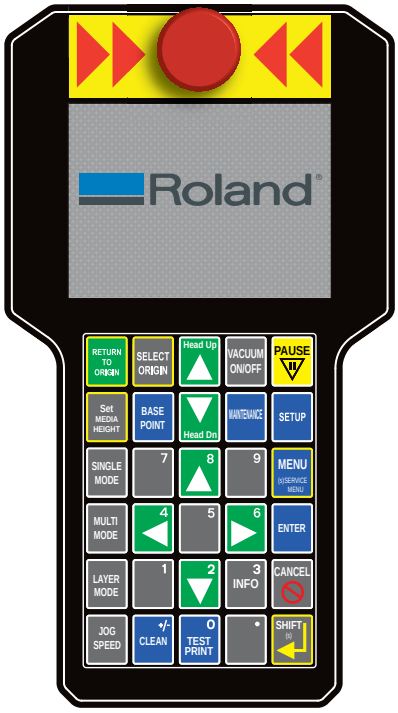
MENU **MENU key**
SET UP **SETUP key**
ENTER **ENTER key**
▲ ▼ ◄ ► **Cursor keys**
PAUSE **PAUSE key**
CLEANING **CLEANING key**
TEST PRINT **TEST PRINT key**
BASE POINT **BASE POINT key**

Printer Display Functions
Items in blue same functions on printer.

Keypad Operations

Handheld Keypad
Emergency Stop (E-Stop)

Function Keys for the LEJ-640FT
Return to Origin
Select Origin
Printer Up/Down Movement
Vacuum ON/OFF
Set Base Point
Maintenance
Setup
Single Mode
Mulit Mode
Layer Mode
INFO
Left/Right Foward/Back Movement
Menu
Cancel
Jog Speed
Clean
Test Print
Set Media Height
SHIFT
Enter



Handheld Keypad

The Roland LEJ-640FT keypad provides more flexibility in accessing the LEJ-640FT by allowing the operator to be closer to the work surface when setting up jobs. With the mobility of this unit, operators experience fewer problems pressing wrong keys by maintaining visual contact with the keypad. The Function Keys on the LEJ-640FT Handheld Keypad access functions and mirror the operation panel on the machine.

The keypad also provides direction with the color scheme: Green keys indicate action or movement; Blue keys indicate functions identical to the printer control panel; and the Yellow key indicates a shift function and pause. The Emergency Stop (E-Stop) Red button located at the top of the keypad allows the operator to immediately shut down the current job and raise the printer head from the material.

Emergency Stop (E-Stop)

The Emergency Stop (E-Stop) button on the handheld keypad and at both sides of the printer cuts power to everything except the control board of the unit, which will go into Emergency Stop mode. This causes the printer head to stop. All job setup information is erased from the system, and operators should wait at least two minutes before engaging the machine and resetting the printer. The E-Stop button must be pulled out when the main power switch is turned on.

Return to Origin

The Return to Origin function allows the operator to return the printer head to the original 0,0,0 axis point. The head position will rise to the highest point in the Z-axis, and the printer will move to the front of the table.

Press Shift

, hold for two seconds, and press Return to Origin

.

Select Origin

The Select Origin function allows the operator to set the X- and Y-axes for up to seven programmable origins.

1. Move the printer head to the starting location for the file.

2. Press Shift

, hold for two seconds, and press Select Origin

.

3. Enter the origin number to be associated with that location.

Printer Up/Down Movement

The Head Up/Dn function moves the printer head up or down within 6 inches, from the highest Head UP location down to the printer table.

Press Head UP

or Head DN

.

Vacuum On/Off

The Vacuum ON/OFF function toggles the vacuum on or off. The vacuum will automatically turn on when the controller receives data for a job and when certain features are active. If no data is sent and no processes are being set after 15 minutes, then the vacuum will automatically turn off.

Press Vacuum ON/OFF

.

Pause

The Pause function allows the operator to instantly stop any motion of the machine or any file. The printer head will remain in its location until the operator selects Head UP or Head DOWN. The operator may resume the project by pressing Pause again.

Press Pause

.

Set Media Height

The Set Media Height function allows the operator to access the menu for selecting the surface setting action.

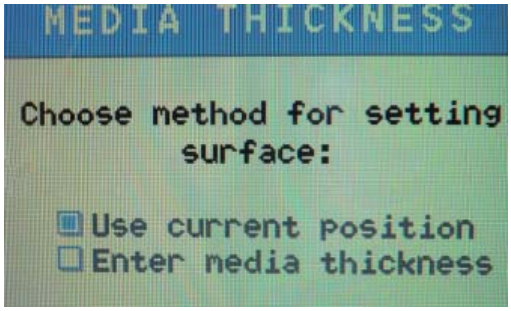
1. Press Set Media Height

.

2. Press Up

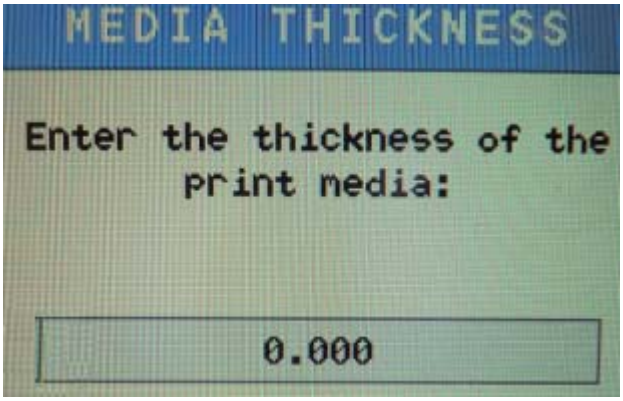
or Down

to select the preferred method.



- Use current position = The current height of the printer head will be used as the surface.

- Enter media thickness = A specific media thickness entered by operator will be used as the surface.



- If operators press Shift

and press Set Media Height

, then the surface will automatically be set to the current position of the material on the table directly beneath the printer head.

Set Base Point

The Base Point function allows the operator to set the origin positions of the X- and Y-axes only. (Operators are only able to set the Z-axis with Set Media Height.) The status of the printer head determines which axis can be set with the Base Point function.

Uncapped Printer Head –

- Press Base Point

to set the Y value.
- Press Base Point

and Shift

to set the X value.

Capped Printer Head –

- Press Base Point

to set the Y value.

Maintenance

The Maintenance function allows the operator to activate the manual cleaning feature. The cleaning process may take up to 10 minutes, and the keypad prompts the operator through each step to access the areas for cleaning. For more information about this, operators should refer to the Operations Manual.

1. Press Maintenance

. The carriage will move to the maintenance station on the left.

2. Follow the prompts on the keypad (e.g., Open Cover, Remove Maintenance Cover) to perform the manual cleaning.

SETUP

The Setup function allows the operator to select the type of material. All LEJ-640FT systems operate with Rigid.

1. Press Shift

, hold for two seconds, and press Setup

.

2. Select Rigid and press Enter

.

Single Mode

The Single Mode function allows the operator to print each job as a separate entity. Single Mode is the default selection.

Press Single Mode

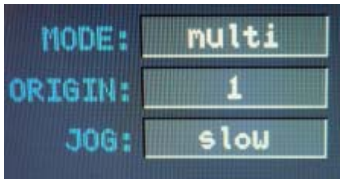
. The mode will be shown on the display.

Multi Mode

The Multi Mode function allows the operator to repeat jobs in sequence at both the same start location and head height.

Press Multi Mode

.

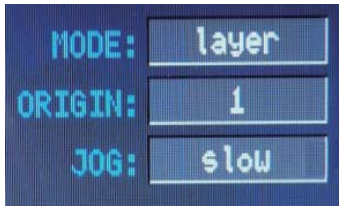


Layer Mode

The Layer Mode function allows the operator to repeat jobs in sequence at the same location and will automatically raise the printer head by 0.06” before beginning the next layer.

Press Layer Mode

.



Info

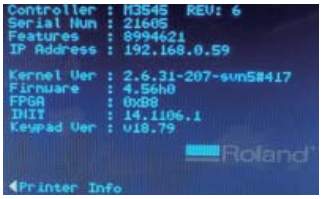
The Info mode allows the operator to review the current status of the printer and table.

1. Press Info

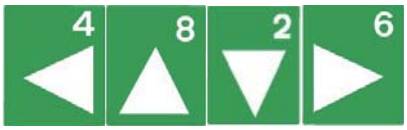
. This will display the printer information.

2. Press Right Arrow

. This will display the table information.



Left/Right/Forward/Back Movement

The Print Head Direction Arrow Keys 

are used to move the printer head and to make selections on the keypad.

1. Left Arrow is the Print Head Left and Left Scroll Key in the menu.
2. Up Arrow is the Print Head Up and Line Up Key in the menu.
3. Down Arrow is the Print Head Down and Line Down Key in the menu.
4. Right Arrow is the Print Head Right and the Right Scroll Key in the menu.

Operators may also use certain function keys in conjunction with the Shift key to home the carriage to the front, middle, or back.

- Home to the front – press Shift

, hold for two seconds, press Down Arrow

- Home to the middle – press Shift

, hold for two seconds, press Five

- Home to the back – press Shift

, hold for two seconds, press Up Arrow

Menu

The Menu function allows the operator to access the menu items from the keypad. Operators can use the operation panel on the machine or the keypad for menu item selection. For more information about this, operators should refer to the Operations Manual (see page .)

Cancel

The Cancel

function allows the operator to return to the prior state in some functions but is mostly used in the Service menu.

JOG Speed

Operators may press Jog Speed

to toggle between three different speeds at which the machine moves the printer head forward or back.

The keypad displays *Jog: fast*, *med*, or *slow*.

Clean

The Clean function allows the operator to activate the automatic cleaning feature. Operators are can use the operation panel on the machine or the keypad for selecting the cleaning mode and ABC printer head sections. For more information about this, operators should refer to the Operations Manual.

Test Print

The Test Print function allows the operator to print a set image in order to complete the default nozzle test print.

Press Test Print

and hold for 1 second or longer. The Nozzle Test image will be printed.

Shift

Press Shift

to access additional functions for a particular function key. Operators will know that the Shift function is active by the green arrow at the bottom of the display.

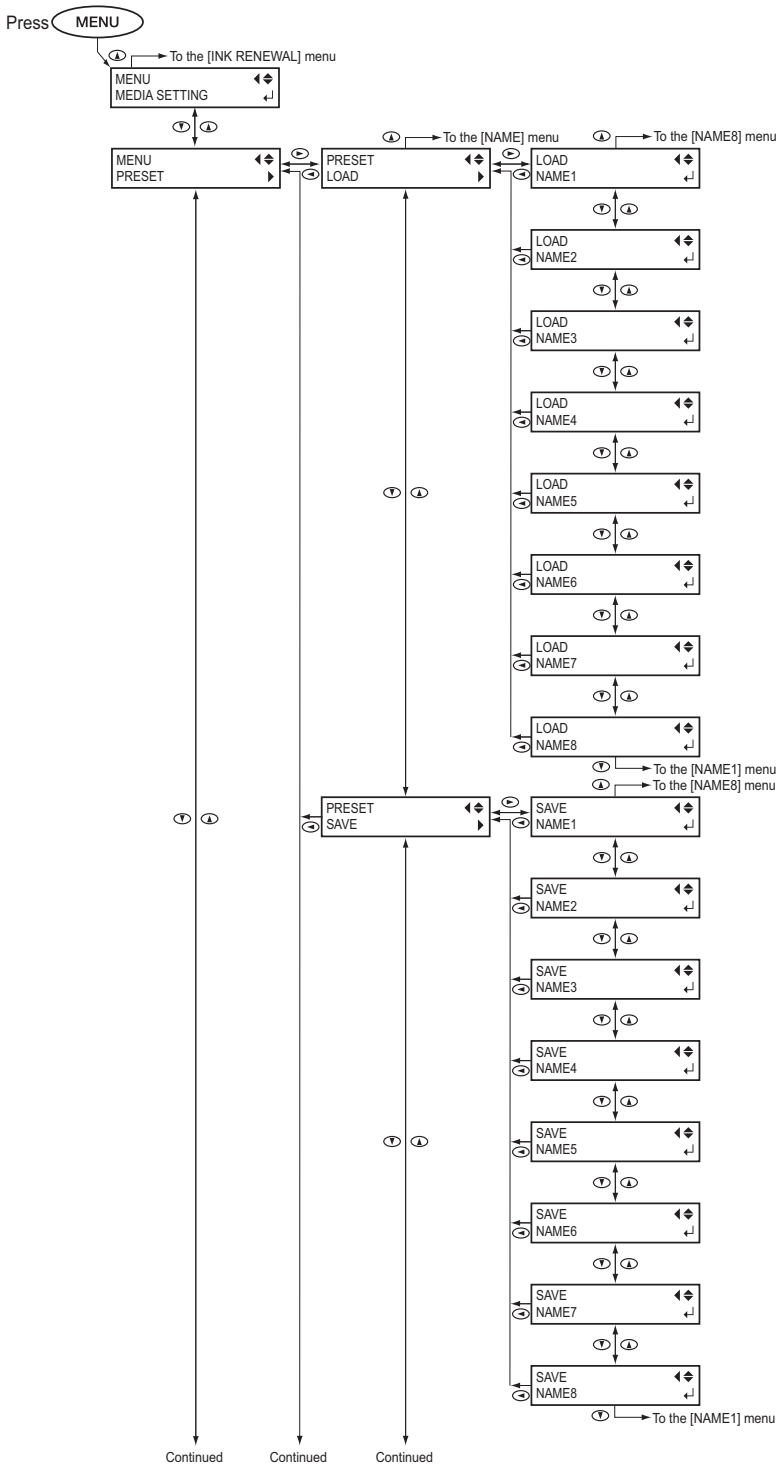
Enter

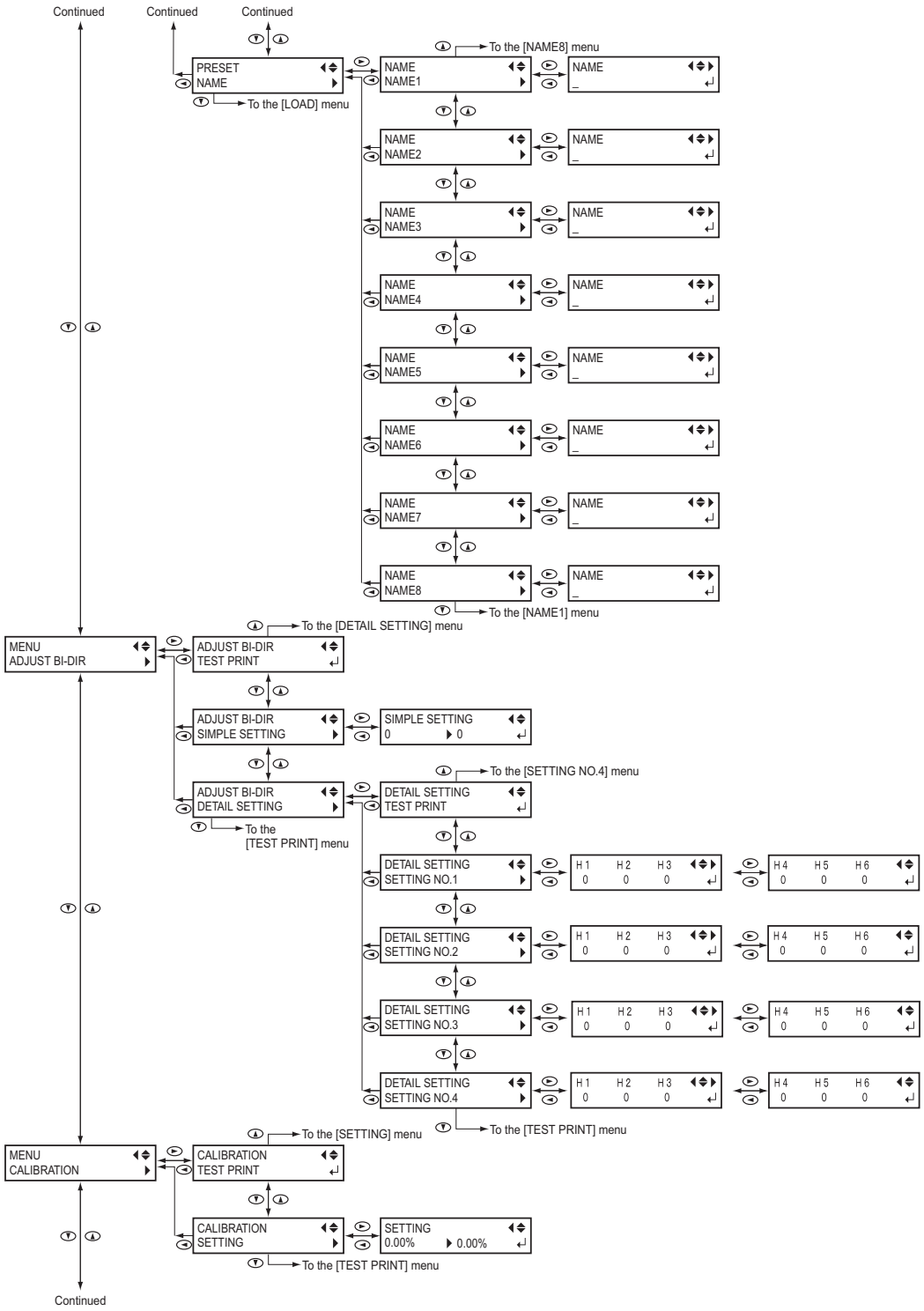
Operators may press Enter

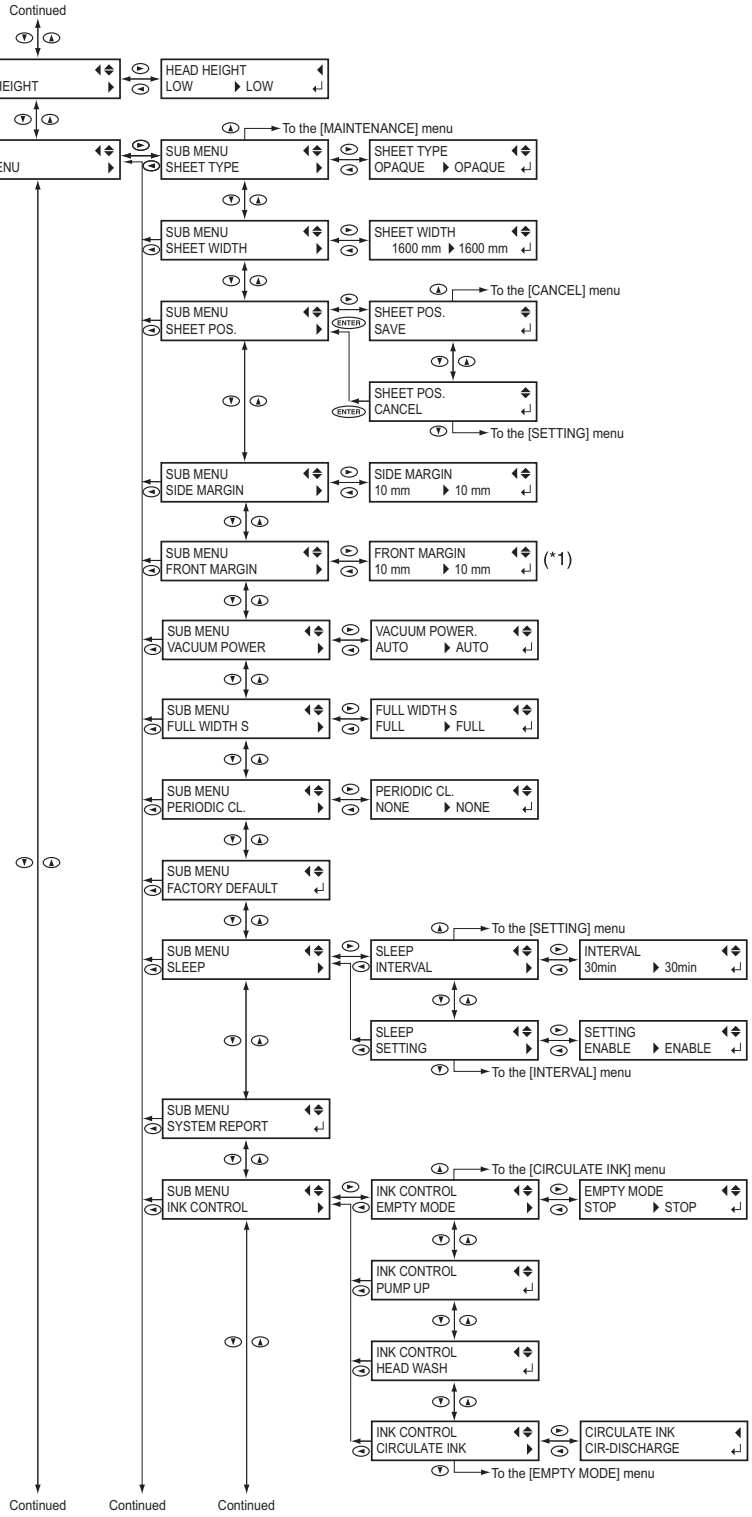
to accept functions, settings, and menu items as directed.

Menu List

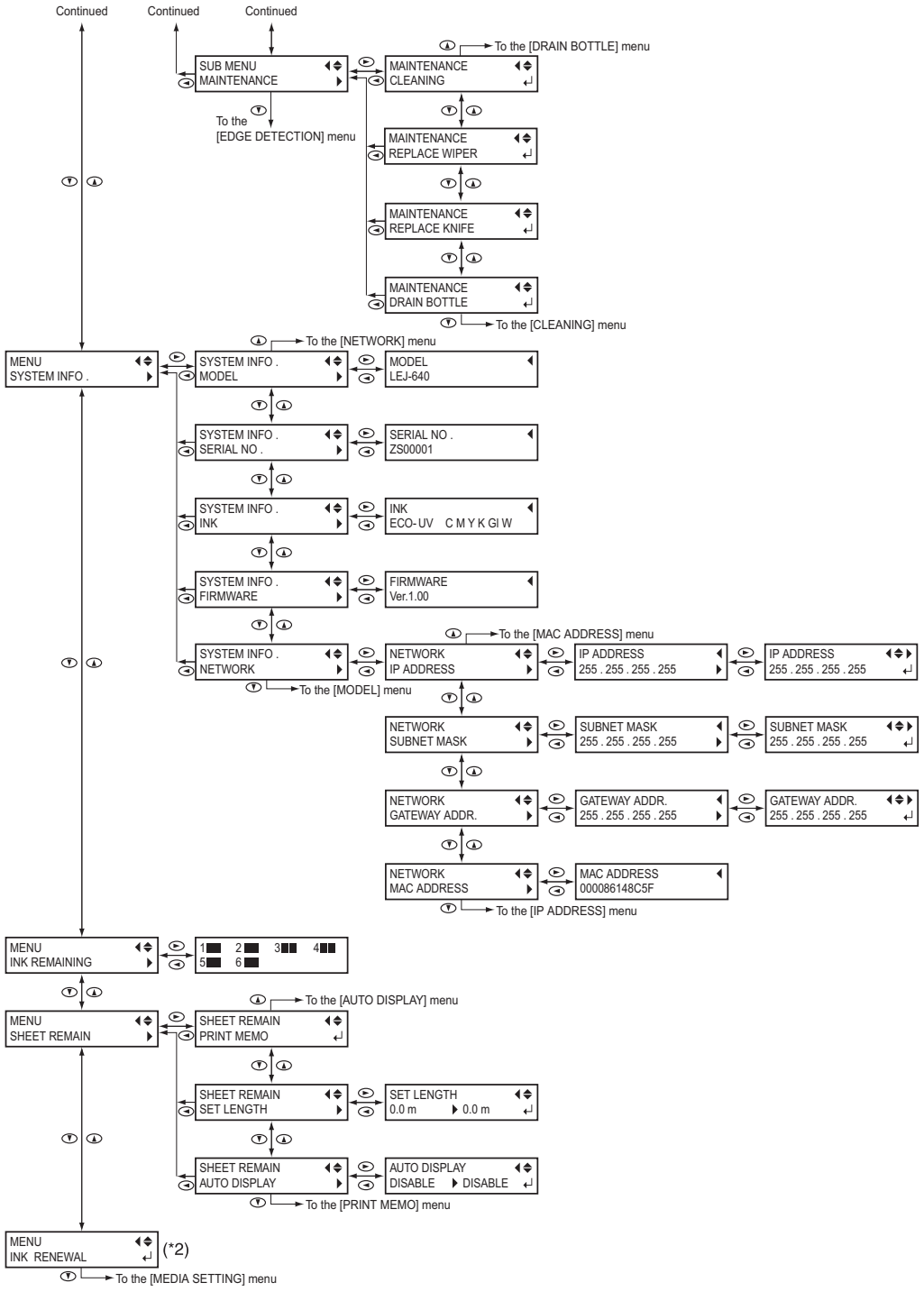
Main Menu




Continued
Continued
Continued
PRESET
NAME
To the [LOAD] menu
To the [NAME8] menu
NAME
NAME1
NAME2
NAME3
NAME4
NAME5
NAME6
NAME7
NAME8
To the [NAME1] menu
To the [DETAIL SETTING] menu
MENU
ADJUST BI-DIR
TEST PRINT
SIMPLE SETTING
0 0
To the [SETTING NO.4] menu
DETAIL SETTING
TEST PRINT
To the [TEST PRINT] menu
SETTING NO.1
SETTING NO.2
SETTING NO.3
SETTING NO.4
H 1 H 2 H 3 H 4 H 5 H 6
0 0 0 0 0 0
To the [SETTING] menu
CALIBRATION
SETTING
0.00% 0.00%
Continued

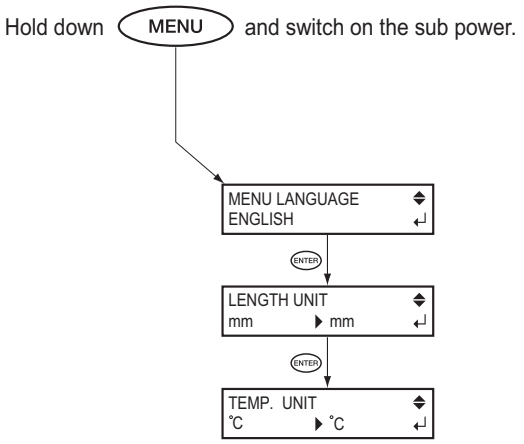


(*1) Only available when "SETUP SHEET" is set to "RIGID".

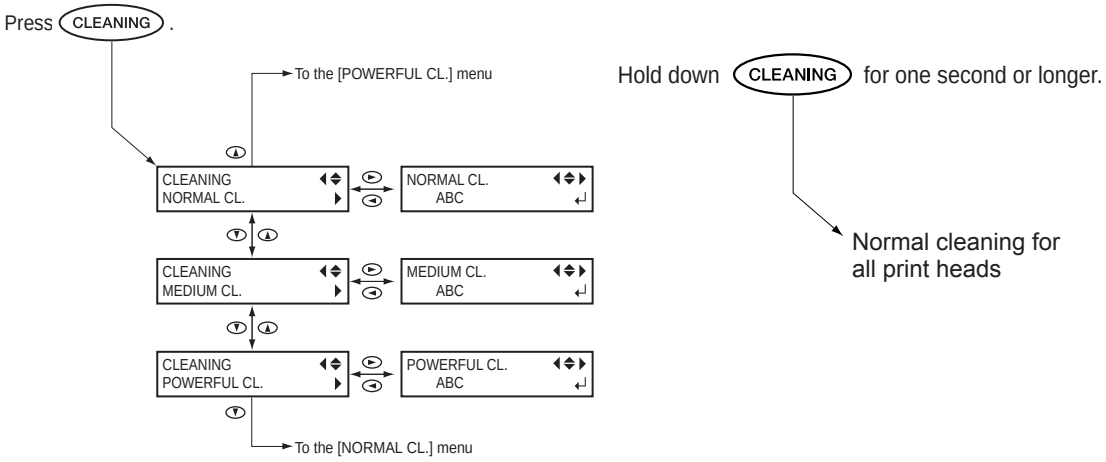


(*2) This is not displayed when "CMYKGlGl" (cyan, magenta, yellow, black, gloss, gloss) is selected as the ink mode.

Language and Unit Menu



Cleaning Menu



⚠ To Ensure Safe Use

Improper handling or operation of this machine may result in injury or damage to property. Points which must be observed to prevent such injury or damage are described as follows.

About ⚠ WARNING and ⚠ CAUTION Notices

⚠ **WARNING**	Used for instructions intended to alert the user to the risk of death or severe injury should the unit be used improperly.
⚠ **CAUTION**	Used for instructions intended to alert the user to the risk of injury or material damage should the unit be used improperly. Note: Material damage refers to damage or other adverse effects caused with respect to the home and all its furnishings, as well to domestic animals or pets.

About the Symbols

	The △ symbol alerts the user to important instructions or warnings. The specific meaning of the symbol is determined by the design contained within the triangle. The symbol at left means "danger of electrocution."
	The ⃠ symbol alerts the user to items that must never be carried out (are forbidden). The specific thing that must not be done is indicated by the design contained within the circle. The symbol at left means the unit must never be disassembled.
	The ● symbol alerts the user to things that must be carried out. The specific thing that must be done is indicated by the design contained within the circle. The symbol at left means the power-cord plug must be unplugged from the outlet.

⚠ Incorrect operation may cause injury

⚠ WARNING

Be sure to follow the operation procedures described in this documentation. Never allow anyone unfamiliar with the usage or handling of the machine to touch it.
Incorrect usage or handling may lead to an accident.

Keep children away from the machine.
The machine includes areas and components that pose a hazard to children and may result in injury, blindness, choking, or other serious accident.

Never operate the machine while tired or after ingesting alcohol or any medication.
Operation requires unimpaired judgment. Impaired judgment may result in an accident.

Never use the machine for any purpose for which it is not intended, or use the machine in an undue manner that exceeds its capacity.
Doing so may result in injury or fire.

For accessories (optional and consumable items, power cord, and the like), use only genuine articles compatible with this machine.
Incompatible items may lead to an accident.

Before attempting cleaning, maintenance, or attachment or detachment of optional items, disconnect the power cord.
Attempting such operations while the machine is connected to a power source may result in injury or electrical shock.

⚠ WARNING

Never attempt to disassemble, repair, or modify the machine.
Doing so may result in fire, electrical shock, or injury. Entrust repairs to a trained service technician.

⚠ CAUTION

Exercise caution to avoid being pinched or becoming caught.
Inadvertent contact with certain areas may cause the hand or fingers to be pinched or become caught. Use care when performing operations.

Never attempt operation while wearing a necktie, necklace, or loose clothing. Bind long hair securely.
Such items may become caught in the machine, resulting in injury.

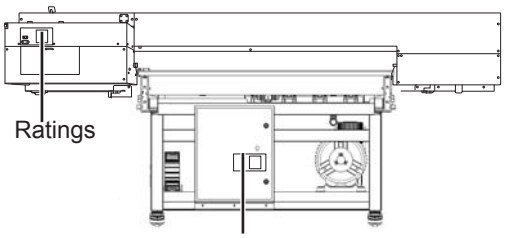
Conduct operations in a clean, brightly lit location.
Working in a location that is dark or cluttered may lead to an accident, such as becoming caught in the machine as the result of an inadvertent stumble.

Never climb or lean on the machine.
The machine is not made to support a person. Climbing or leaning on the machine may dislodge components and cause a slip or fall, resulting in injury.

⚠ Danger of electrical short, shock, electrocution, or fire

⚠ WARNING

Connect to an electrical outlet that complies with this machine's ratings (for voltage, frequency, and current).
Incorrect voltage or insufficient current may cause fire or electrical shock.



Never use out of doors or in any location where exposure to water or high humidity may occur. Never touch with wet hands.
Doing so may result in fire or electrical shock.

Never allow any foreign object to get inside. Never expose to liquid spills.
Inserting objects such as coins or matches or allowing beverages to be spilled into the ventilation ports may result in fire or electrical shock. If anything gets inside, immediately disconnect the power cord and contact your authorized Roland DG Corp. dealer.

⚠ WARNING

Never place any flammable object nearby. Never use a combustible aerosol spray nearby. Never use in any location where gases can accumulate.
Combustion or explosion may be a danger.

Handle the power cord, plug, and electrical outlet correctly and with care. Never use any article that is damaged.
Using a damaged article may result in fire or electrical shock.

When using an extension cord or power strip, use one that adequately satisfies the machine's ratings (for voltage, frequency, and current).
Use of multiple electrical loads on a single electrical outlet or of a lengthy extension cord may cause fire.

Connect to ground.
This can prevent fire or electrical shock due to current leakage in the event of malfunction.

Position so that the power plug is within immediate reach at all times.
This is to enable quick disconnection of the power plug in the event of an emergency. Install the machine next to an electrical outlet. Also, provide enough empty space to allow immediate access to the electrical outlet.

If sparking, smoke, burning odor, unusual sound, or abnormal operation occurs, immediately unplug the power cord. Never use if any component is damaged.
Continuing to use the machine may result in fire, electrical shock, or injury. Contact your authorized Roland DG Corp. dealer.

⚠ Important notes about the power cord, plug, and electrical outlet

Required Power Configuration

Voltage and Frequency:

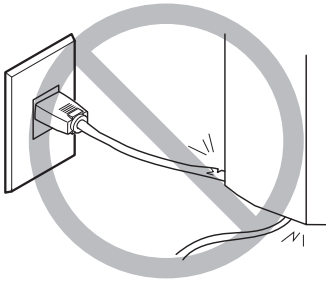
Single Phase 220 V AC, 50/60 Hz

Required power capacity: **30A Max**

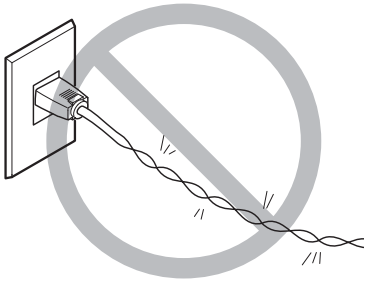
Number of power outlets: 1 (Outlet plug provided)

Electrician is REQUIRED!

*If altering plug installation consult with licensed electrician for local electrical codes.

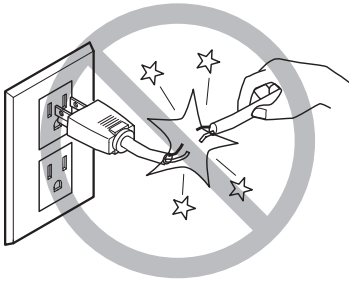


Never place any object on top or subject to damage.

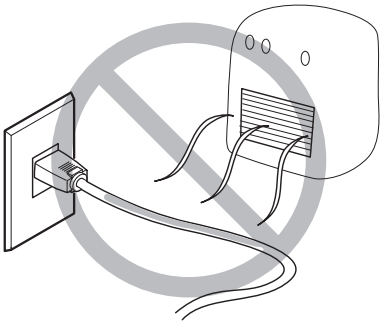


Never bend or twist with undue force.

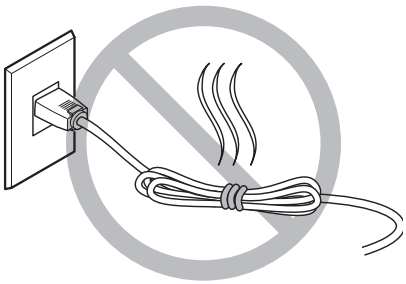
Never allow to get wet.



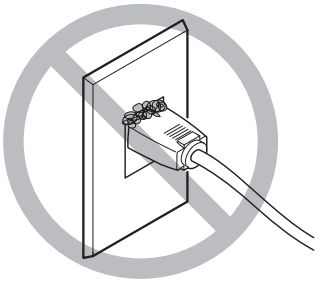
Never pull with undue force.



Never make hot.



Never bundle, bind, or roll up.



Dust may cause fire.

⚠ Ink, cleaning liquid, and discharged fluid are flammable and toxic

⚠ WARNING

Keep open flame away from the work area.
Ink and discharged fluid are flammable.

Never store ink, cleaning liquid, or discharged fluid in any of the following locations.
- **Any location exposed to open flame**
- **Any location where high temperature may occur**
- **Near bleach or any other such oxidizing agent or explosive material**
- **Any location within the reach of children**

Fire may be a danger. Accidental ingestion by children may pose a health hazard.

Never place an ink cartridge in fire.
Ink may flow out, catch fire, and spread fire to other nearby objects.

⚠ WARNING

Never drink or sniff ink, cleaning liquid, or discharged fluid, or allow them to come in contact with the eyes or skin.
Doing so may be hazardous to the health.

⚠ CAUTION

Ensure adequate ventilation for the work area.
Failing to perform ventilation may result in a health hazard or danger of combustion due to ink fumes.

Never allow an ink cartridge to be subjected to impact, and never attempt to disassemble.
Ink may leak.

⚠ In the event of ingestion or physical distress

- **In the event of contact with the eyes, immediately flush with water for at least 15 minutes. If eye irritation continues, seek treatment by a physician.**
- **In the event of contact with skin, immediately wash with soap. If irritation or inflammation occurs, seek treatment by a physician.**
- **In the event of ingestion, do not induce vomiting, and immediately seek treatment by a physician. Forcibly inducing vomiting may lead to danger of choking.**
- **If odor leads to physical distress, move to a well-ventilated location and rest quietly. If dizziness or nausea persists, seek treatment by a physician.**

⚠ This machine weighs 2612 lbs (1184.7 kg). Media weight MAX 200 lbs (90.7kg).

⚠ WARNING

Install the machine in a location that is level, stable, and able to bear the weight of the machine.
The total weight of the machine may reach 2612 lbs (1184.7 kg.) or more. Installation in an unsuitable location may cause a major accident, including tip over, fall, or collapse.

Unloading and emplacement are operations that must be performed by 6 persons or more.
Tasks that require undue effort when performed by a small number of persons may result in physical injury. Also, if dropped, such items may cause injury.

Be sure to lock and level the table's casters.
If the machine should begin to topple, a major accident may result, including crushing of the appendages or the body.

⚠ WARNING

When storing media, implement adequate safety measures to ensure that the stored media will not fall or topple over.
Danger exists of becoming pinned under the media and suffering serious injury.

Handling media is an operation that must be performed by two persons or more, and care must be taken to prevent falls.
Attempting to lift heavy media in a manner that taxes your strength may cause physical injury.

⚠ This machine uses ultraviolet light.

⚠ CAUTION

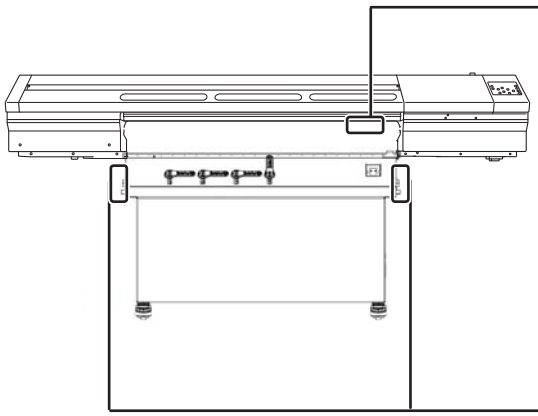
Never look at the blue-white (ultraviolet) light emitted from the print-head area for an extended time.
Looking directly at the ultraviolet light from up close for an extended period may result in eye injury.

⚠ Caution: Ultraviolet Light

This machine is fitted with covers to keep external leakage of ultraviolet light at low levels, but incorrect handling or operation can lead to physical injury due to ultraviolet light. The extent of injury depends on the intensity and wavelength of the ultraviolet light, and the length of time of exposure. Prolonged exposure to strong ultraviolet light of hazardous wavelengths can cause injury to the eyes or skin. Exercise caution.

⚠ Warning Labels

Warning labels are affixed to make areas of danger immediately clear. The meanings of these labels are as follows. Be sure to heed their warnings.
Also, never remove the labels or allow them to become obscured.



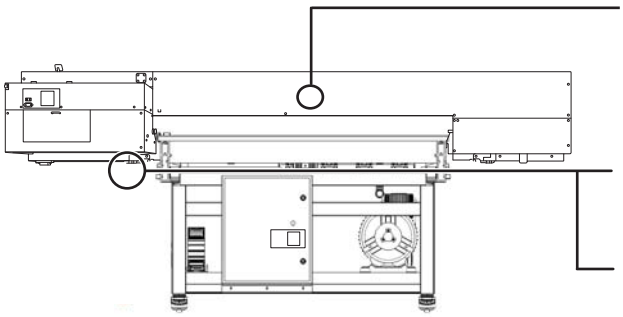
Flammable
Ink and discharged fluid are flammable. Keep away from open flame.

Ink Is Toxic
Ink and discharged fluid are toxic. Avoid contact with the body. Use only in a well-ventilated area.

Caution: Ultraviolet Light
Never look directly from up close for a prolonged period.

Caution: Moving Print Heads
The print heads inside the cover move at high speed and pose a hazard. Never insert the hand or fingers into the gap.

Caution: Pinching Hazard
Be careful not to allow the fingers to become pinched when loading media or closing covers.



Caution: Ultraviolet Light
Never look directly from up close for a prolonged period.

Flammable
Ink and discharged fluid are flammable. Keep away from open flame.

Ink Is Toxic
Ink and discharged fluid are toxic. Avoid contact with the body. Use only in a well-ventilated area.

⚠ Pour utiliser en toute sécurité

La manipulation ou l'utilisation inadéquates de cet appareil peuvent causer des blessures ou des dommages matériels. Les précautions à prendre pour prévenir les blessures ou les dommages sont décrites ci-dessous.

Avis sur les avertissements

⚠ **ATTENTION**	Utilisé pour avertir l'utilisateur d'un risque de décès ou de blessure grave en cas de mauvaise utilisation de l'appareil.
⚠ **PRUDENCE**	Utilisé pour avertir l'utilisateur d'un risque de blessure ou de dommage matériel en cas de mauvaise utilisation de l'appareil. *Par dommage matériel, il est entendu dommage ou tout autre effet indésirable sur la maison, tous les meubles et même les animaux domestiques.

À propos des symboles

	Le symbole △ attire l'attention de l'utilisateur sur les instructions importantes ou les avertissements. Le sens précis du symbole est déterminé par le dessin à l'intérieur du triangle. Le symbole à gauche signifie "danger d'électrocution."
	Le symbole ⃠ avertit l'utilisateur de ce qu'il ne doit pas faire, ce qui est interdit. La chose spécifique à ne pas faire est indiquée par le dessin à l'intérieur du cercle. Le symbole à gauche signifie que l'appareil ne doit jamais être démonté.
	Le symbole ● prévient l'utilisateur sur ce qu'il doit faire. La chose spécifique à faire est indiquée par le dessin à l'intérieur du cercle. Le symbole à gauche signifie que le fil électrique doit être débranché de la prise.

⚠ L'utilisation incorrecte peut causer des blessures

⚠ ATTENTION

S'assurer de suivre les procédures d'utilisation décrites dans la documentation. Ne jamais permettre à quiconque ne connaît pas le fonctionnement ou la manutention de l'appareil de le toucher.
L'utilisation ou la manutention incorrectes peuvent causer un accident.

Garder les enfants loin de l'appareil.
L'appareil comporte des zones et des composants qui présentent un danger pour les enfants et qui pourraient causer des blessures, la cécité, la suffocation ou d'autres accidents graves.

Ne jamais faire fonctionner l'appareil après avoir consommé de l'alcool ou des médicaments, ou dans un état de fatigue.
L'utilisation de l'appareil exige un jugement sans faille. L'utilisation avec les facultés affaiblies pourrait entraîner un accident.

Ne jamais utiliser l'appareil à des fins autres que celles pour lesquelles il est conçu. Ne jamais l'utiliser de manière abusive ou d'une manière qui dépasse sa capacité.
Le non-respect de cette consigne peut causer des blessures ou un incendie.

Utiliser uniquement des accessoires d'origine (accessoires en option, articles consommables, câble d'alimentation et autres articles semblables), compatibles avec l'appareil.
Les articles incompatibles risquent de causer des accidents.

⚠ ATTENTION

Débrancher le câble d'alimentation avant de procéder au nettoyage ou à l'entretien de l'appareil, et avant d'y fixer ou d'en retirer des accessoires en option.
Tenter ces opérations pendant que l'appareil est branché à une source d'alimentation peut causer des blessures ou un choc électrique.

Ne jamais tenter de démonter, de réparer ou de modifier l'appareil.
Le non-respect de cette consigne risque de provoquer un incendie, un choc électrique ou des blessures. Confier les réparations à un technicien ayant la formation requise.

⚠ PRUDENCE

Faire preuve de prudence pour éviter l'écrasement ou le coincement.
La main ou les doigts peuvent être écrasés ou coincés s'ils entrent en contact avec certaines surfaces par inadvertance. Faire preuve de prudence pendant l'utilisation de l'appareil.

Ne jamais faire fonctionner l'appareil si on porte une cravate, un collier ou des vêtements amples. Bien attacher les cheveux longs.
Ces vêtements ou ces objets peuvent être coincés dans l'appareil, ce qui causerait des blessures.

Utiliser l'appareil dans un endroit propre et bien éclairé.
Travailler dans un endroit sombre ou encombré peut causer un accident; l'utilisateur risque, par exemple, de trébucher malencontreusement et d'être coincé par une partie de l'appareil.

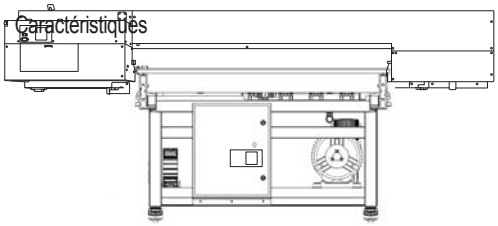
⚠ PRUDENCE

Ne jamais grimper ni s'appuyer sur la machine.
La machine n'est pas conçue pour supporter le poids d'une personne. Grimper ou s'appuyer sur la machine peut déplacer des éléments et causer un faux pas ou une chute, ce qui causerait des blessures.

⚠ Risque de décharge ou de choc électrique, d'électrocution ou d'incendie

⚠ ATTENTION

Brancher à une prise électrique conforme aux caractéristiques de cet appareil (tension, fréquence et courant).
Une tension incorrecte ou un courant insuffisant peuvent causer un incendie ou un choc électrique.



Ne jamais utiliser à l'extérieur ni à un endroit où l'appareil risque d'être exposé à de l'eau ou à une humidité élevée. Ne jamais toucher l'appareil avec des mains mouillées.
Le non-respect de cette consigne risque de provoquer un incendie ou un choc électrique.

⚠ ATTENTION

Ne jamais insérer d'objet étranger dans l'appareil. Ne jamais exposer l'appareil aux déversements de liquides.
L'insertion d'objets comme des pièces de monnaie ou des allumettes, ou le déversement de liquides dans les orifices de ventilation peuvent causer un incendie ou un choc électrique. Si un objet ou du liquide s'infiltre dans l'appareil, débrancher immédiatement le câble d'alimentation et communiquer avec le représentant Roland DG Corp. autorisé.

Ne jamais placer d'objet inflammable à proximité de l'appareil. Ne jamais utiliser de produit inflammable en aérosol à proximité de l'appareil. Ne jamais utiliser l'appareil dans un endroit où des gaz peuvent s'accumuler.
Une combustion ou une explosion pourraient se produire.

⚠ Risque de décharge ou de choc électrique, d'électrocution ou d'incendie

⚠ ATTENTION

Manipuler le câble d'alimentation, la fiche et la prise électrique correctement et avec soin.
Ne jamais utiliser un article endommagé, car cela pourrait causer un incendie ou un choc électrique.

Si une rallonge ou une bande d'alimentation électrique sont utilisées, s'assurer qu'elles correspondent aux caractéristiques de l'appareil (tension, fréquence et courant).
L'utilisation de plusieurs charges électriques sur une prise unique ou une longue rallonge peut causer un incendie.

Mise à la terre.
La mise à la terre peut prévenir un incendie ou un choc électrique dus à une fuite de courant en cas de défaillance.

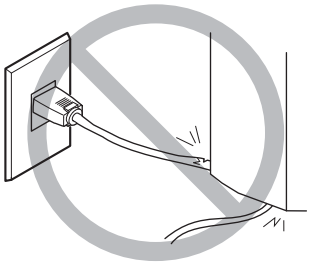
Placer l'appareil de façon à ce que la fiche soit facile d'accès en tout temps.
Ainsi, l'appareil pourra être débranché rapidement en cas d'urgence. Installer l'appareil près d'une prise électrique. En outre, prévoir suffisamment d'espace pour que la prise électrique soit facile d'accès.

⚠ ATTENTION

S'il se produit des étincelles, de la fumée, une odeur de brûlé, un bruit inhabituel ou un fonctionnement anormal, débrancher immédiatement le câble d'alimentation. Ne jamais utiliser si un composant est endommagé.
Continuer à utiliser l'appareil peut causer un incendie, un choc électrique ou des blessures. Communiquer avec le représentant Roland DG Corp. Autorisé.

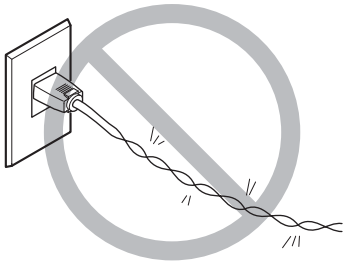
Ne pas utiliser le cordon électrique fourni avec d'autres produits.

⚠ Remarques importantes à propos du câble d'alimentation, de la fiche et de la prise électrique

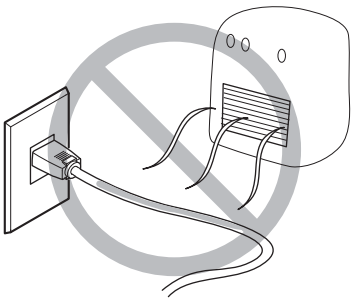


Ne jamais déposer aucun objet sur le câble, sur la fiche ou sur la prise car cela risque de les endommager.

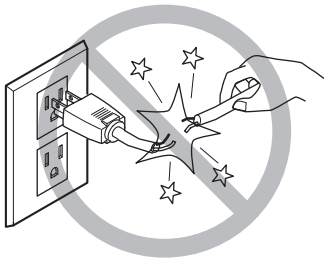
Ne jamais laisser l'eau toucher le câble, la fiche ou la prise.



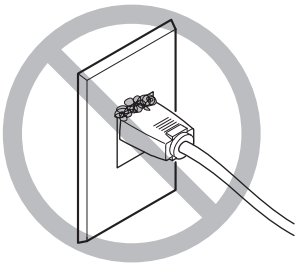
Ne jamais plier ni tordre le câble avec une force excessive.



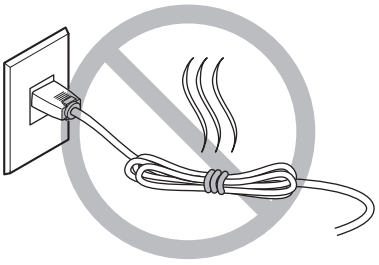
Ne jamais chauffer le câble, la fiche ou la prise.



Ne jamais tirer sur le câble ou la fiche avec une force excessive.



La poussière peut causer un incendie.



Ne jamais plier ni enrouler le câble.

⚠ L'encre, les liquides nettoyants et les liquides usées sont inflammables et toxiques

⚠ ATTENTION

Ne pas approcher une flamme nue de l'espace de travail.
L'encre et les liquides usés sont inflammables.

Ne jamais entreposer d'encre, de liquide de nettoyage ou des liquides usés dans les endroits suivants :
- **un endroit exposé à une flamme nue;**
- **un endroit où il y a risque de température élevée;**
- **près d'eau de Javel, d'un autre agent d'oxydation ou de matériel explosif;**
- **tout endroit à la portée d'enfants.**

Il y a risque d'incendie. L'ingestion accidentelle par un enfant peut présenter un risque pour la santé.

Ne jamais incinérer une cartouche d'encre.
De l'encre pourrait couler, s'enflammer et le feu se répandre à des objets proches.

⚠ ATTENTION

Ne jamais boire l'encre, le liquide de nettoyage ni les liquides usés, ne pas en respirer les vapeurs et ne pas laisser les produits entrer en contact avec les yeux ou la peau.
Cela est dangereux pour la santé.

⚠ PRUDENCE

S'assurer que le lieu de travail est bien aéré.
L'absence d'aération adéquate peut créer une situation dangereuse pour la santé ou un risque de combustion à cause des vapeurs qui émanent de l'encre.

Ne jamais soumettre une cartouche d'encre à des chocs. Ne jamais tenter d'ouvrir une cartouche d'encre.
De l'encre pourrait s'échapper.

⚠ En cas d'ingestion ou de trouble physique

- **En cas de contact avec les yeux : rincer immédiatement et abondamment à l'eau courante pendant au moins 15 minutes. Si les yeux sont toujours irrités, consulter un médecin.**
- **En cas de contact avec la peau : laver immédiatement à l'eau et au savon. En cas d'irritation ou d'inflammation de la peau : consulter un médecin.**
- **En cas d'ingestion : ne pas provoquer le vomissement et demander immédiatement l'aide d'un médecin. Provoquer le vomissement peut créer un risque de suffocation.**
- **Si l'odeur cause un trouble physique, amener la personne dans un endroit bien aéré et la faire se reposer. Si l'étourdissement ou la nausée persistent, consulter un médecin.**

⚠ Le poids de cet appareil est de 2612 lbs (1184.7 kg). Le poids du support est de 200 lbs (90.7kg).

⚠ ATTENTION

Installer l'appareil à un endroit stable et plat et capable de supporter son poids.
Le poids total de l'appareil peut être d'au moins 400 kg (882 lb.). Installer l'appareil à un endroit inapproprié peut provoquer un accident grave comme le renversement, la chute ou l'écrasement.

Le déchargement et la mise en place doivent être faits par au moins six personnes.
Les tâches qui exigent un effort trop grand si elles sont exécutées par un petit nombre de personnes peuvent être cause de blessures. La chute d'articles très lourds peut aussi causer des blessures.

⚠ ATTENTION

S'assurer de verrouiller les roulettes de la base.
Si l'appareil devait commencer à basculer, il s'ensuivrait un accident grave, par exemple l'écrasement de membres ou du corps.

Prendre les mesures de sécurité adéquates pour l'entreposage des rouleaux de support pour s'assurer qu'ils ne rouleront pas, ne tomberont pas et ne se renverseront pas.
Il y a risque d'être écrasé par le support et de subir des blessures graves.

La manutention du support en rouleau doit être faite par deux personnes ou plus et il faut prendre des précautions pour éviter les chutes.
Tenter de soulever des objets trop lourds peut causer des blessures.

⚠ Cet appareil utilise des rayons ultraviolets.

⚠ PRUDENCE

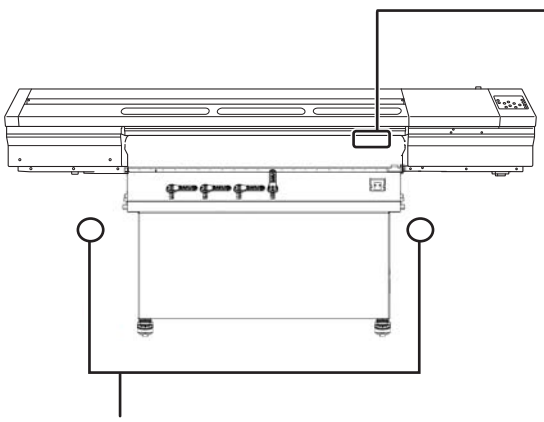
Ne jamais regarder pendant de longues périodes le rayonnement blanc bleuté (ultraviolet) émis par la tête d'impression.
Le fait de regarder directement et de près le rayonnement ultraviolet pendant une période prolongée peut causer des lésions oculaires.

⚠ Attention : Rayonnement ultraviolet

Cet appareil est muni de couvercles destinés à empêcher les fuites de rayonnement ultraviolet à faible niveau, mais sa manipulation ou son utilisation incorrectes peuvent causer des lésions dues au rayonnement ultraviolet. La gravité des lésions est fonction de l'intensité et de la longueur d'onde du rayonnement ultraviolet et de la durée de l'exposition. L'exposition prolongée à un fort rayonnement ultraviolet de longueur d'onde dangereuse peut causer des lésions oculaires ou cutanées. La prudence est de rigueur.

⚠ Vignettes d'avertissement

Des vignettes d'avertissement sont apposées pour qu'il soit facile de repérer les zones dangereuses. La signification des vignettes est donnée ci-dessous. Respecter les avertissements. Ne jamais retirer les vignettes et ne pas les laisser s'encrasser.



Attention : Risque de pincement
Ne jamais toucher inutilement le rouleau compensateur. Faire attention pour éviter de coincer les doigts.

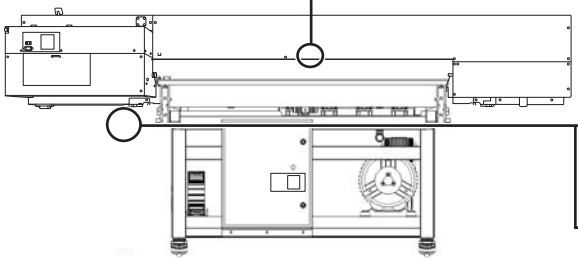
Inflammable
L'encre et les liquides usés sont inflammables. Les garder loin de toute flamme nue.

L'encre est toxique
L'encre et les liquides usés sont toxiques. Éviter tout contact avec le corps. Utiliser uniquement dans un endroit bien aéré.

Attention : Rayonnement ultraviolet
Ne jamais regarder de près et directement pendant une période prolongée.

Attention : Têtes d'impression mobiles
Les têtes d'impression sous le couvercle se déplacent à haute vitesse et représentent un danger. Ne jamais insérer la main ou les doigts dans l'ouverture.

Attention : Risque de pincement
Faire attention de ne pas coincer les doigts pendant le chargement du support ou lors de la fermeture du couvercle.



Attention : Rayonnement ultraviolet
Ne jamais regarder de près et directement pendant une période prolongée.

Inflammable
L'encre et les liquides usés sont inflammables. Les garder loin de toute flamme nue.

L'encre est toxique
L'encre et les liquides usés sont toxiques. Éviter tout contact avec le corps. Utiliser uniquement dans un endroit bien aéré.

Important Notes on Handling and Use

This machine is a precision device. To ensure the full performance of this machine, be sure to observe the following important points. Failure to observe them may not only result in loss of performance, but may also cause malfunction or breakdown.

Printer Unit & Table

This machine is a precision device.

- **Handle carefully, and never subject the machine to impact or excessive force.**
- **Never needlessly put your hand or fingers along side rails between printer and table, inside the cover, the ink-cartridge ports, or other internal areas of the machine.**
- **Never shove or jam media under printer. Use proper printer height to Load or Unload media.**

Install in a suitable location.

- **Install in a location having the specified temperature and relative humidity.**
- **Install and level machine properly.**
- **Install in a quiet, stable location offering good operating conditions.**

The print heads and the UV emitter are delicate devices.

- **Never needlessly touch or allow media to scrape them. Failure to handle with care may cause damage.**
- **The print heads may be damaged if allowed to dry out. The machine prevents desiccation automatically, but improper operation may render this feature inoperative. Operate properly, as specified in this manual.**
- **Never allow the machine to stand with an ink cartridge removed. Remaining ink in the printer may harden and clog the print heads.**
- **The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use.**

Ink Cartridges

Ink cartridges come in various types.

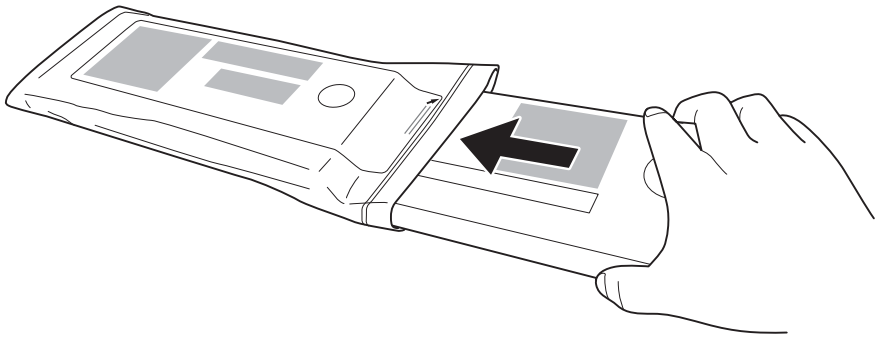
- **Use a type that is compatible with the printer. Also, be sure to use only genuine items from Roland DG Corp.**

Never subject to impact or attempt to disassemble.

- **Never drop or shake forcefully. The impact may rupture the internal pouch and cause the ink to leak.**
- **Never attempt to disassemble.**
- **Never attempt to refill the ink.**
- **If ink gets on your hands or clothing, wash it off as soon as possible. Removal may become difficult if allowed to stand.**

Storage

- **Use up the ink before the expiration date printed on the ink cartridge.**
- **Store the ink cartridge in a location avoiding direct sunlight or strong illumination.**
- **Store the ink cartridge unopened in a well-ventilated location at a temperature of over 5˚C (41˚F) and under 35˚C (95˚F) and relative humidity of 20 to 80%.**
- **Once opened, store the ink cartridge in the sealed original (shading) bag.**



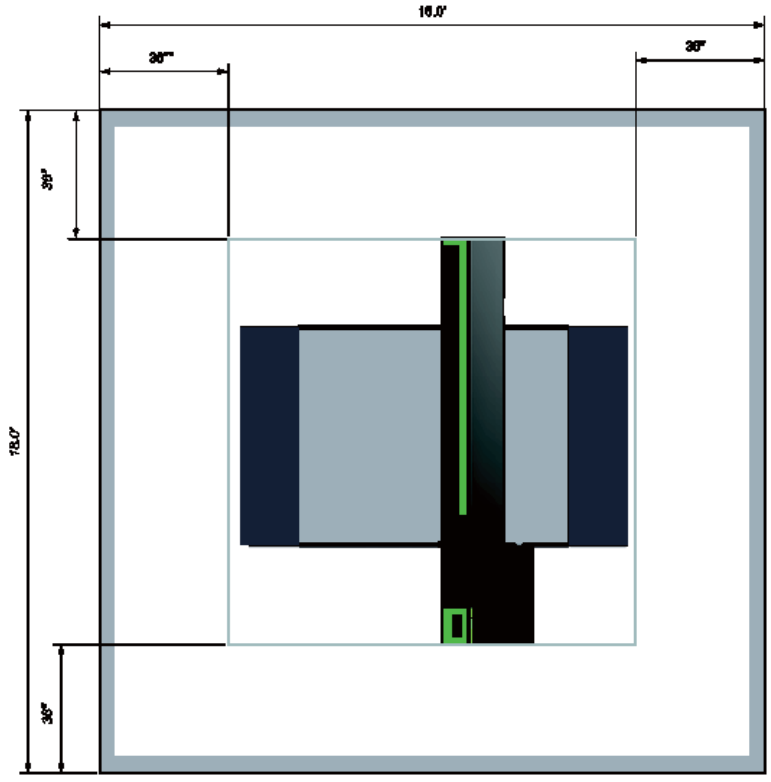
Table

This flatbed table is a large, robust machine but a precision device ... not a TABLE!

- **Never leave or store media on the table surface unless in use.**
- **Do NOT use the print table surface as a cutting table.**
- **Never needlessly put your hand or fingers along side rails between printer and table.**
- **Never shove or jam media under printer. Use proper printer height to Load or Unload media.**

Install in a suitable location.

- **Install in a location having the correct specified temperature and relative humidity.**
- **Install and level machine properly.**
- **Install in a clean location offering good operating conditions.**
- **Make sure there is ample space available to work around the printer. Loading and unloading large sheets of media may require two people to properly handle material without damage to the printer.**
- **Make sure ALL media is stored flat. Media will bow if stored on its side causing uneven print surface.**
- **Make sure All media is stored in a clean environment. Excessive dust build-up and grease will make cleaning media more time consuming and can cause damage to the print heads.**



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Prepare the Media

Type of Media

In this manual, the substrate used for output is called "media." There are the following main three media types used in this machine.

- **Roll media: Media wound onto a paper tube (Important: Roll media can be used as a sheet)**
- **Sheet media: Media not wound onto a paper tube such as standard-size media**
- **Rigid media: Sheet media that is rigid**

*Roll media, sheet media, and rigid media Loading Options can be selected, HOWEVER it is best to use the Rigid setting for all medias.
For detailed information about each media, contact your media supplier. Media is also available from our following website.
http://www.rolanddg.com/

Usable Media

This machine cannot necessarily output to every kind of media. When selecting media, be sure to carry out testing in advance to make sure that satisfactory output quality is obtained.

Roll media

Size

Width
210 to 1625 mm (8.3 to 64 inches)

Maximum media thickness
152.4 mm (6.0 inches)

Maximum Weight

90.7185 kg (200 lb.)

Other Conditions

Media such as the following cannot be used as applicable for LEJ_640FT Unit

- Media which is severely warped
- Media that is bent or crushed
- Media that has eneven edges
- Media that bends under its own weight when loaded
- Media that is uneven
- Media that has an electrostatic charge

Sheet media / Rigid media

Size

Width
250 to 1625 mm (9.8 to 64 inches)

Maximum media thickness
152.4 mm (6.0 inches)

Maximum Weight

90.7185 kg (200 lb.)

Other Conditions

- Certain metallic and glass materials cannot be used even if they satisfy the conditions listed above.
- When using media that is warped, print quality will be affected if the ripples in the media are 0.5 mm (0.02 inch) or higher.*

* Adjusting settings can improve print quality.
☞ P. 58, "Configuring Unidirectional Printing (Roland VersaWorks)"

- Type of Media
  In this manual the term "MEDIA" is referred to a wide selection of rigid material (up to a thick-ness of max 6 inches) which are sheets or panels of:
  - Polyurethane
  - Polystyrene
  - Cardboard
  - Aluminium
  - Pleated material
  - Transparent Acrylics
  - DiBOND
  - COREX
  - Kapa
  - PET
  - Polyethylene
  - Polycarbonate
  - Polypropylene
  - PVC

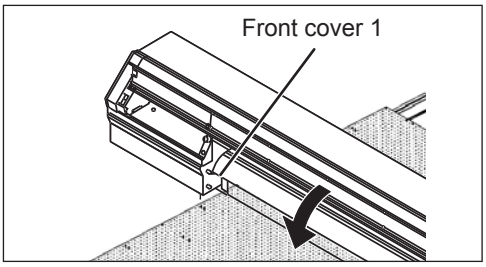
- Sheet media: Media not wound onto a paper tube such as standard-size media
- Rigid media: Sheet media that is rigid
- Media is also available from our following website: **http://www.rolanddg.com/**

Switch On

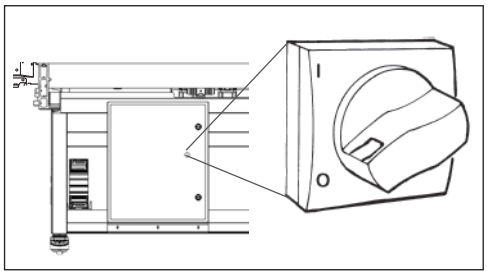
Switch On

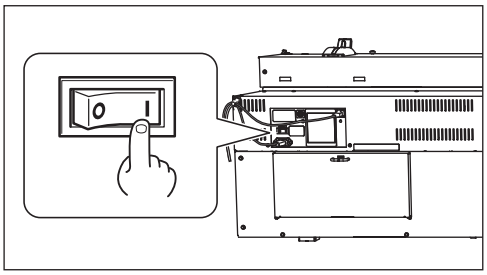
Procedure

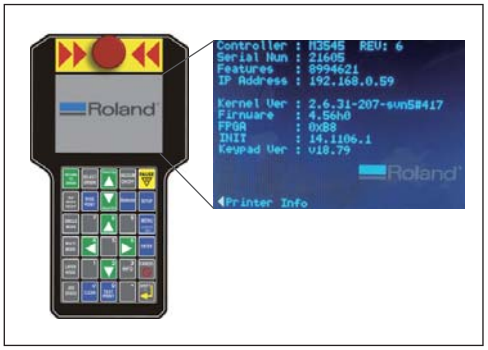
❶ **Close the front cover 1.**



❷ **Turn on the General Power switch on the electrical box, then turn main power on printer.**

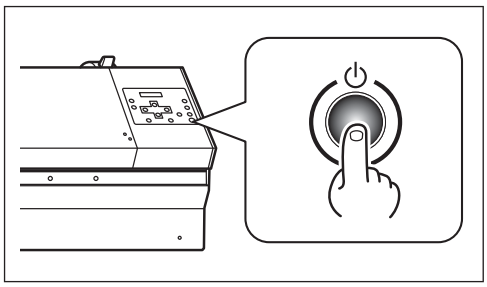






The Keypad display will show Initialization proceedure.

❸ **Press the sub power button.**



Note: For installation of the ink cartridge and selection of the language displayed on the display screen, refer to Setup Guide.

NOTE: Once the sub power is On the printer and Keypad will prompt to Enter media type (Rigid/Roll/TU1/TU2). ***Always select RIGID.***

5

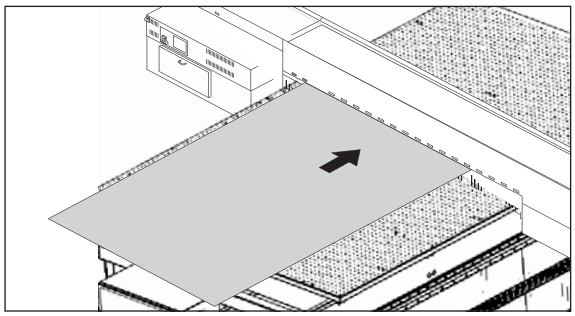
SETUP SHEET
◆▶ RIGID L 99.9m

THICKNESS
6.5mm ↵

Press ◄ ► to select "RIGID."
Press SET UP.

Press ▲ ▼ to enter the thickness of the rigid media. Since the Keypad is used to set media thickness, it is suggested to leave the value at 0.0 inches.

6 **Prepare media for placement and printing.**

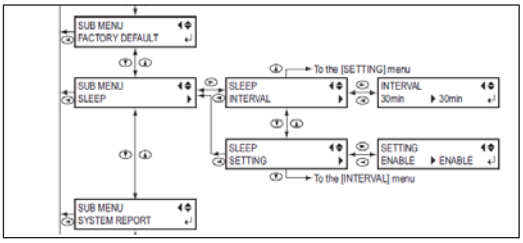


The Power-saving Feature (Sleep Mode)

This machine is provided with a power-saving feature that switches to a low-power "sleep mode" when a fixed interval passes with no operation. The factory default for the time after which the machine switches to the sleep mode is 30 minutes. When the machine is in the sleep mode, the sub power switch flashes slowly. Using the operation panel or performing operations such as sending print data from the computer (when media is loaded) restores the machine to its normal mode.
This setting of sleep mode can be changed. However, we recommend leaving the power-saving feature on and setting the activation time for the sleep mode to 30 minutes or less to reduce power consumption and so on.

☞ P. 21, "Setting the Interval until Activation of the Sleep Mode (Power Saving Function)."

☞ P. 21, "Deactivating the Sleep Mode (Power Saving Function)"



Important Points to Check Before Printing

Three Important Points (Measures for UV Reflected Light and Ink Mist)

On this machine, ink affixed on the surface of the print heads might be cured by reflection of the UV-LED lamp light and ink mist (ink splash upon printing). If ink affixed on the surface of the print heads is cured, it might cause dot drop-outs, and if you use the product without taking any measures, it might cause a failure which requires replacement of the print heads.

While daily cleaning is important to prevent dot drop-outs, there are also three important points to check before printing. Be sure to check the three points given below:

1. You cannot use an object which reflects light as a print object (media).

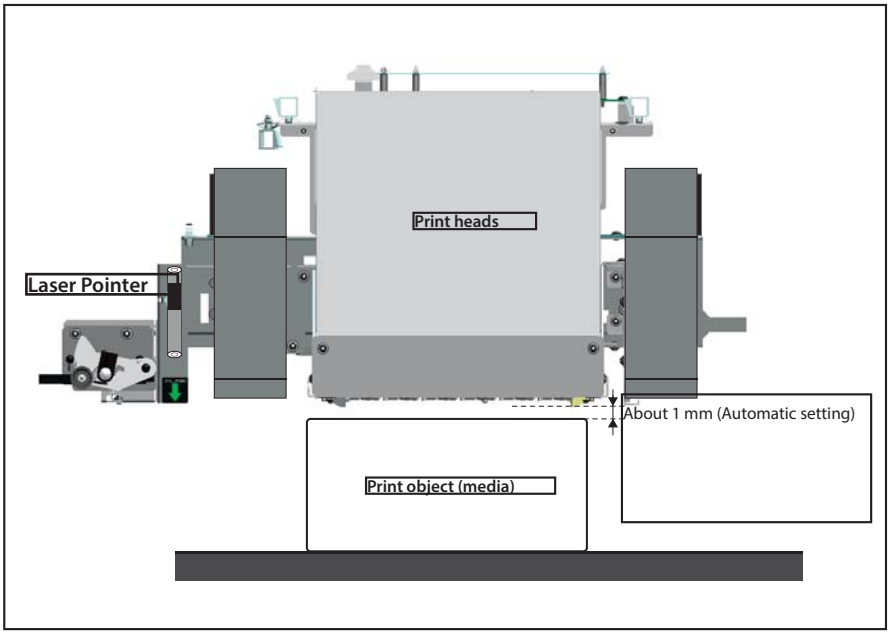
Mirrors and stainless materials, etc. which are likely to reflect the UV-LED lamp light promote curing of the surface of the print heads, and therefore they cannot be used as a print object (media).

2. Make the distance between the surface of the print object (media) and the print heads as short as possible.

As the distance between the surface of the print object (media) and the print heads increases, the likelihood of ink mist increases. When setting the height of media manually, make the distance as short as possible. When the height is automatically set, their distance is about 1 mm (39.4 mils).

☞ "Setting Height of Media Automatically"

☞ "Setting Height of Media Manually"



3. A fixture might be required according to the size and shape of the print object (media). *Users NOT using jigs as described below, print head failure may occur and will not be covered under warranty.

According to the size and shape of the print object (media), the distance between the print object (media) and print heads may increase with the likelihood of ink mist increased. In the direction to which the print heads move, there must be a print object (media) and/or a jig in the areas of 40 mm (1.6 inches) on both right and left sides of the portion (width) of the data to be printed. In that case, the difference in height between the surfaces of the print object (media) and jig must be less than 2 mm (78.7 mils).

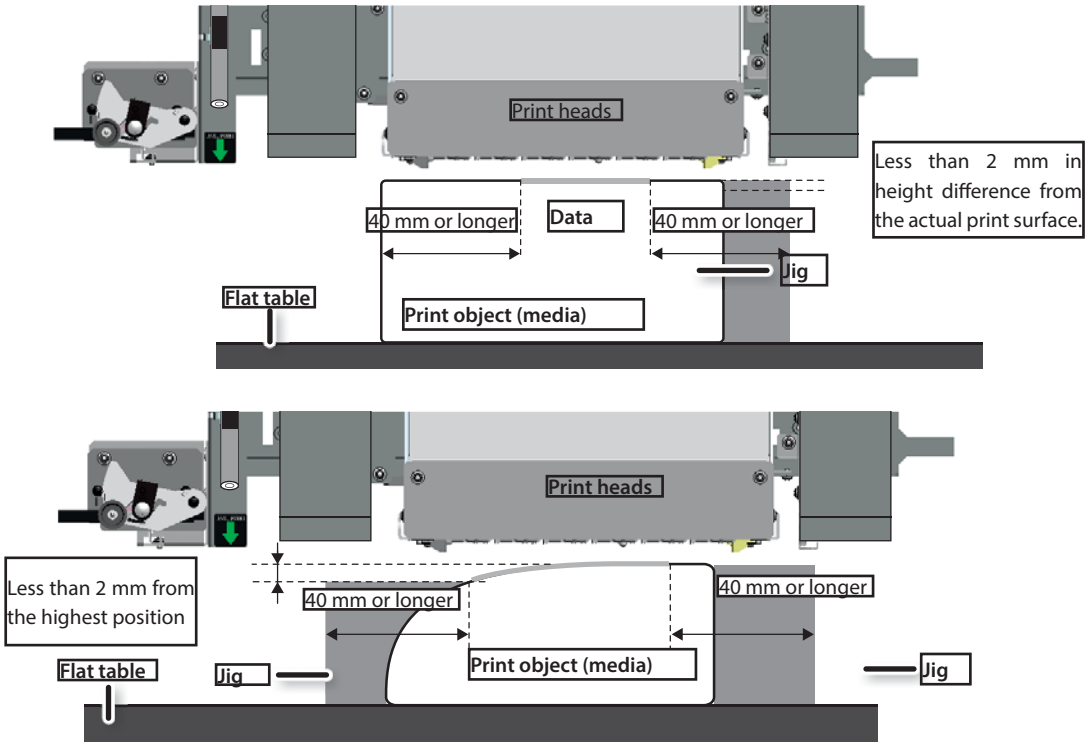
☞ "Setting Height of Media Automatically"

☞ "Setting Height of Media Manually"

☞ "Height Settings When the Print Surface is Uneven"

When a fixture is required:

- The print object (media) is not large enough to spread over the areas of 40 mm on both right and left sides of the portion (width) of the data to be printed.
- The variation in height of the print object (media) surface is 2 mm or more.



Loading Media

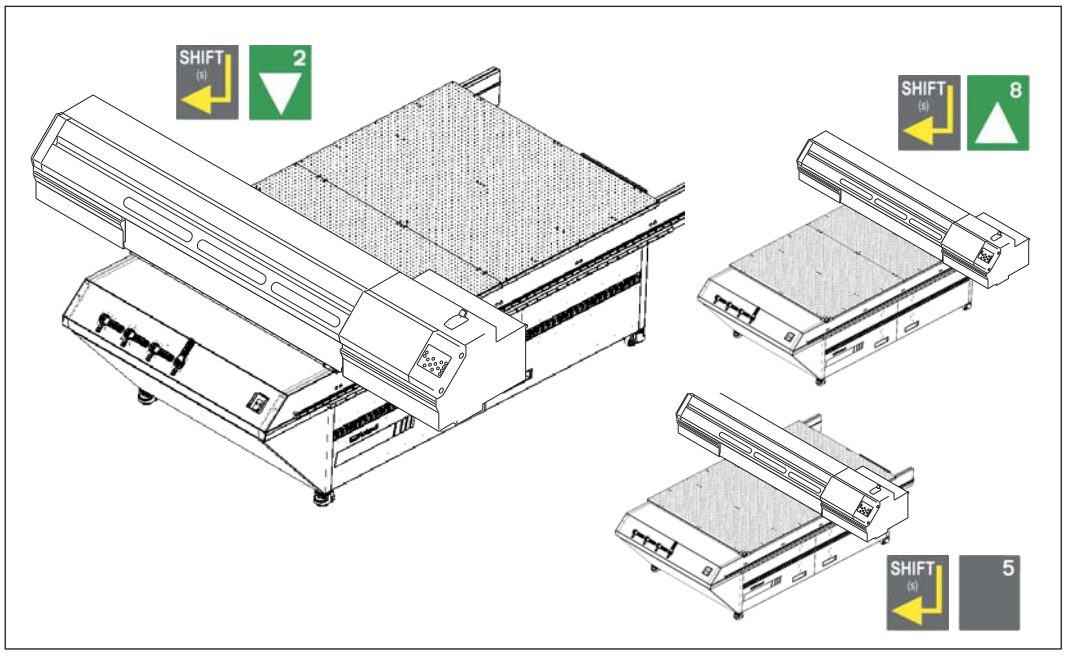
Use the following procedure to load media.

1. Raise the Printer to 1 of 3 default origins.

❶ **Select the origin desired for media loading depending on the size of the media or access location.**
(For example: front or rear loading)

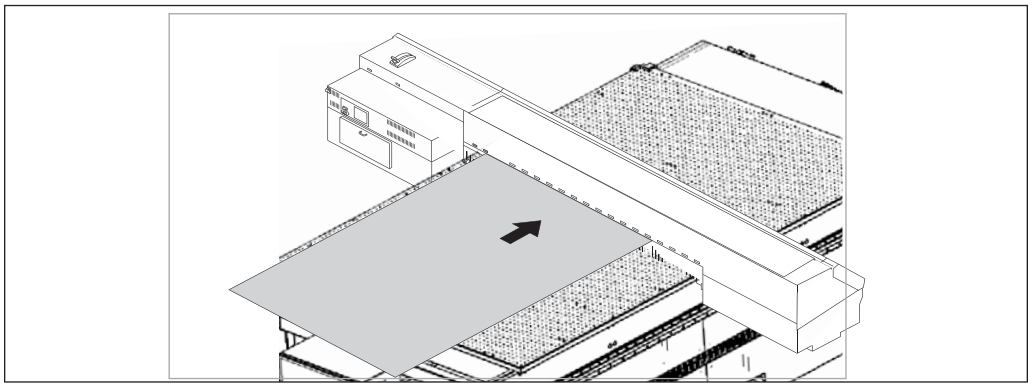
➢Press Shift / Down Arrow on the keypad to move the printer to the front loading position.
➢Press Shift / Middle on the keypad to move the printer to the middle loading position.
➢Press Shift / Up Arrow on the keypad to move the printer to the rear loading position.

❷ **The Printer will raise and move to the selected position.**



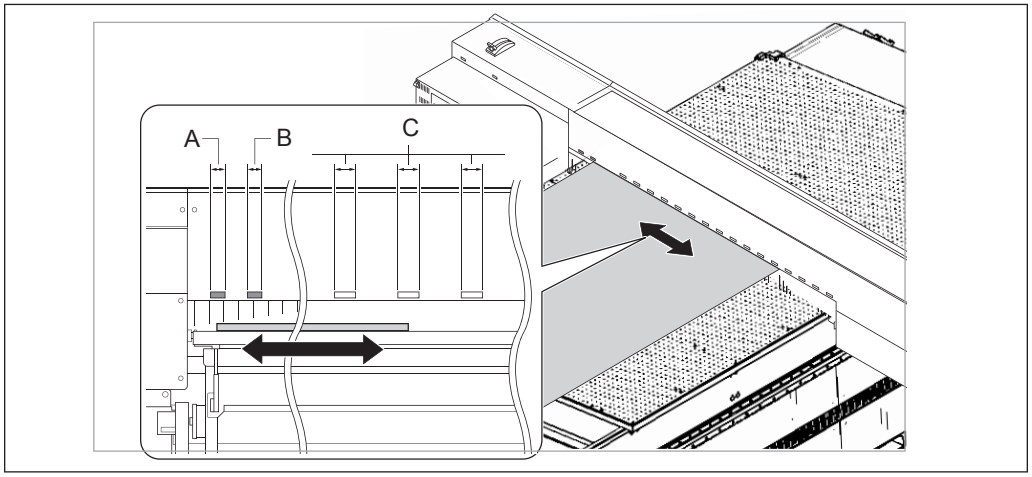
2. Place the rigid media on the table.

1 Pass the rigid media through the machine.

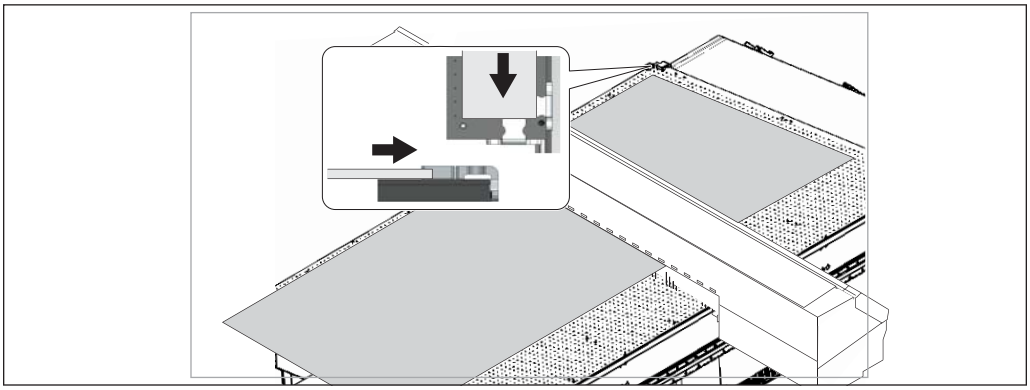


POINT!
When a protective sheet is attached to the reverse side of the media, load the media without peeling off the protective sheet so that the media will pass through the machine smoothly.

2 Align the left and right position of the media.
Adjust the position of the media so that the right edge is positioned within one of the areas marked "C", and so that the left edge is positioned within either area "A" or area "B".

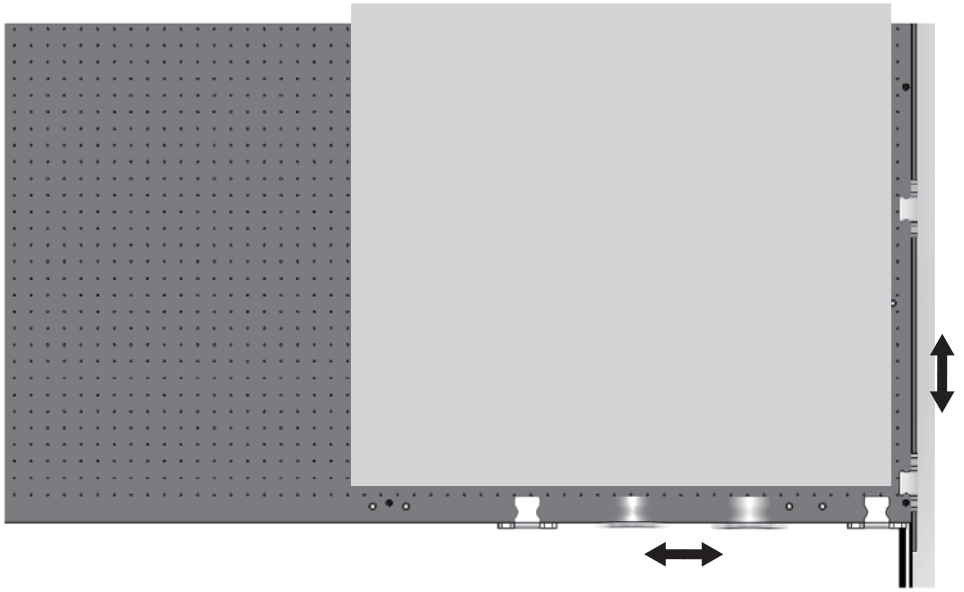


❸ **Slide the media up to the alignment guides.**

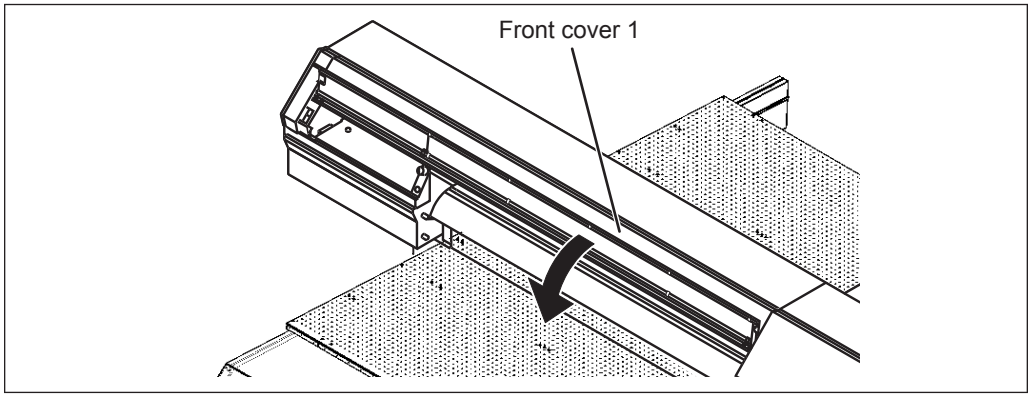


IMPORTANT!

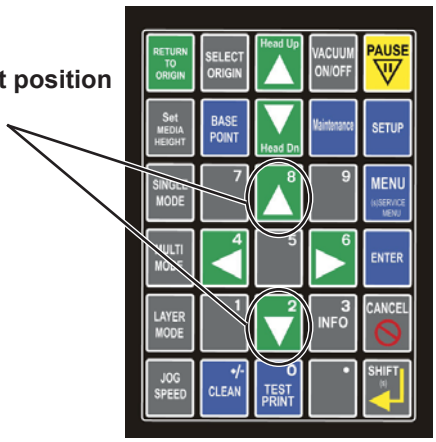
The alignment guides are positionable and can be moved across and down the flatbed table depending on the size of media. Place media against the guides being careful not to push to aggressively against the guides for best alignment.



4 **Turn vacuum ON and close the front cover 1.**

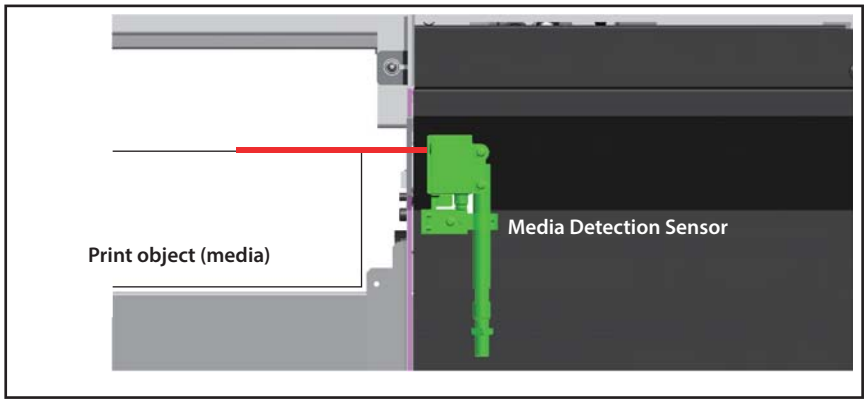


5 **Using the Keypad move the printer to the correct position above the media.**



6 **Press**

Using the media detection sensor, the printer will automatically adjust to the height of the current media.



3. Enter the thickness of the rigid media.

❶ SETUP SHEET
◆▶ RIGID L 99.9m

Press ◄ ► to select "RIGID."
Press SET UP.

❷ THICKNESS ▲▼
6.5mm ↵

Press ▲ ▼ to enter the thickness of the rigid media. Since the Keypad is used to set media thickness, it is suggested to leave the value at 0.0 inches as media thickness is controlled more accurately by automatic head height as previously set. (See previous page).

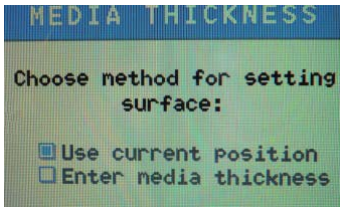
Thickness can be set from 0.0 to 13.0 mm (0.000 to 0.5 inches) and will be added to the automatic media thickness which may cause print qulaity loss.

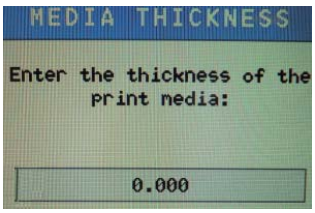
❸ **Press ENTER. The printer automatically adjusts to the set position.**
If the print heads do not make contact with the media, automatic detection begins and SET UP flashes.

Automatic Detection OK
When initialization has finished, SET UP lights up and the printable width is displayed.
Continue to "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing

Note:

❹ **Press Set MEDIA HEIGHT on the KeyPad and the display will prompt to choose method for setting surface: Use current position or Enter media thickness.**





Configuring Uni-directional or Bi-directional Printing (Roland VersaWorks)

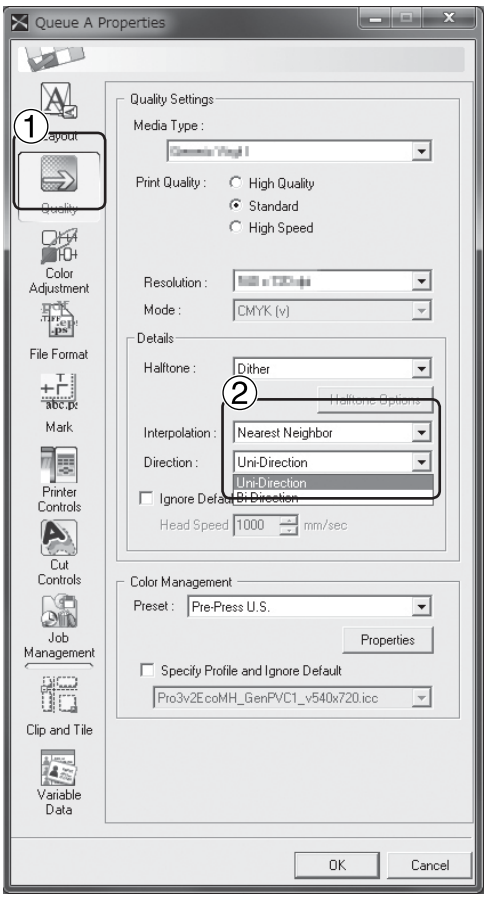
* For details about RVW, refer to the RVW instruction manual.

Procedure

1 Open the "Que Properties" window (or the "Job Setting" window)

Select the input folder to be used.

2



① Click
② Select "Uni-Direction" or "Bi-Direction" from [Direction] under "Details".

"Que Properties" window
(The setting item and the method in "Job Setting" window are the same as this procedure.)

***Proceed to "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)".**

Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)

Perform the initial adjustment (correction for misalignment in bidirectional printing more precisely) of this machine. This adjustment is necessary in the following cases. When changing the print-head height, change the height before performing this adjustment.

☞ P. 52-53, "Adjusting the Print-Head Height to Match Media Thickness"

- **When using this machine for the first time**
- **When changing the media to use**
- **When further correction is required to improve printing, such as when simple correction is performed for misalignment in bidirectional printing. ☞P. <?>, "Correcting for Misalignment in Bidirectional Printing"**

1. Output a test pattern.

❶ **Press MENU.**

❷ MENU / ADJUST BI-DIR ◆▲▼ ▶

Press ▼ several times until the screen shown on the left appears.
Press ► and then ▲.

❸ ADJUST BI-DIR ◆▲▼ / DETAIL SETTING ▶

Press ►.

❹ DETAIL SETING ◆▲▼ / TEST PRINT ↵

Press ENTER.
A test pattern is output.
When printing ends, press MENU and then ◄.

❺ **Remove the front cover 2.**

❻ **Press ▼ and feed the media forward to a position where you can clearly see the condition of the test print.**
This operation is not necessary when using roll media or sheet media. Proceed to step ❼.

❼ DETAIL SETING ◆▲▼ / TEST PRINT ↵

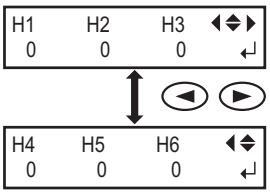
Repeat steps ❶ to ❸ until the screen shown on the left appears.
Press ▼.

❽ DETAIL SETTING ◆▲▼ / SETTING NO.1 ▶

Press ►.

2. Enter the adjustment value.

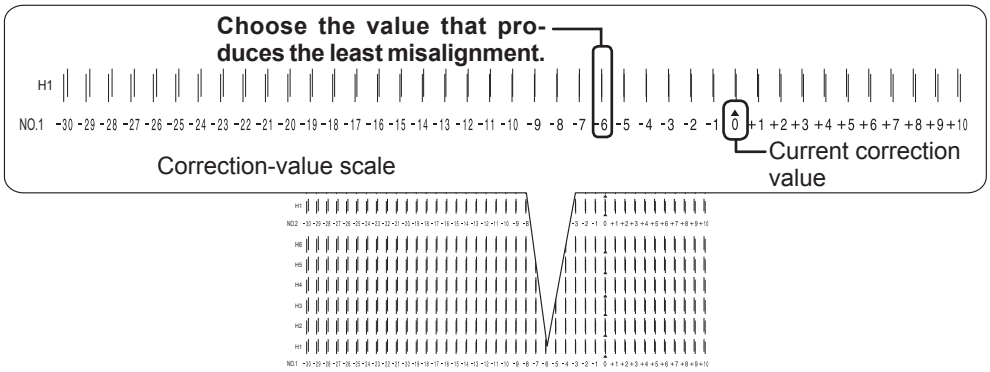
❶



Press ◄ ► to select one from H1 to H6.
Press ▲ ▼ to decide a correction value for the selected item from H1 to H6.
Press ENTER to finish making the settings for [SETTING NO.1].

To decide a Correction Value

Choose the value that produces the least misalignment of 2lines.


Choose the value that produces the least misalignment.
H1
NO.1 -30 -29 -28 -27 -26 -25 -24 -23 -22 -21 -20 -19 -18 -17 -16 -15 -14 -13 -12 -11 -10 -9 -8 -7 -6 -5 -4 -3 -2 -1 0 +1 +2 +3 +4 +5 +6 +7 +8 +9 +10
Correction-value scale
Current correction value

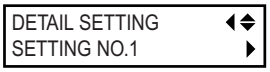
If the Printing-test Results Are Difficult to Interpret

Examine the results from different angles in a well-lighted location. Take advantage of reflected light to enable visual checking.

If you cannot see "H5" or "H6" (such as when using white media with no shine)

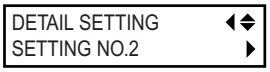
You may not be able to see "H5" or "H6" when using certain media, such as white media with no shine. In this case, set "H5" and "H6" to the same value as "H4."

❷



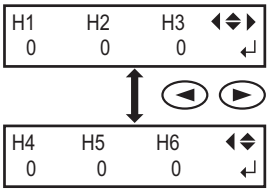
Press ▼.

❸



In the same manner as performed for [SETTING NO.1], set the correction values for the other items from [SETTING NO.2] to [SETTING NO.4].

❹



When correction value settings end, press ENTER.

5 **Attach the front cover 2.**
When using rigid media, press ▲ and pull back the media to the appropriate position.

6

W XXXmm

Press MENU ◄ in this order to go back to the original screen.

Reminder: The Keypad can be used for all Menu functions of the printer console.

Using Media Settings

About [MEDIA SETTING] menu

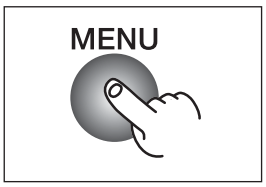
To ensure the optimal output according to the media size and type, various setting items are provided in this machine. However, it is hard work to perform these settings one by one referring to this document. So, this machine provides the [MEDIA SETTING] menu that guides these settings in the interactive mode. Using this menu, you can set all of the basic settings only by setting according to the instructions on the display.
Since the setting details can be stored as the preset menu, you can promote your operation efficiently saving the setup steps when using the same type of media. Once storing the basic settings as the preset, you can do fine adjustment according to need.

Setup of Media ([MEDIA SETTING] menu)

Note: If any setting is not needed for each setting item, you can go to the next menu by selecting [NEXT].

1. Starting the [MEDIA SETTING] menu.

❶ **Load appropriate media.**
Check that media is flat and no warping is found on the media. If any warping or unevenness exists, replace the media with a flat, appropriate media.

❷ 

Press (MENU) **.**

❸

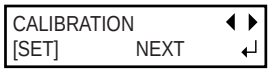
When the left figure is displayed, press (ENTER) **.**

2. Perform the position correction of feed direction (Alleviate Horizontal Stripes).

POINT!

Feed direction means the feed direction of the media. Perform the correction adjusting to the media in advance because horizontal stripes are more likely to occur during printing when the movement distance of the media changes subtly depending on the kind or thickness of the media.

❶



Press ◄ to select [SET].
Press ENTER to enable the setting.
The test pattern of feed correction is output.

❷

When the left figure is displayed, press ENTER .

❸

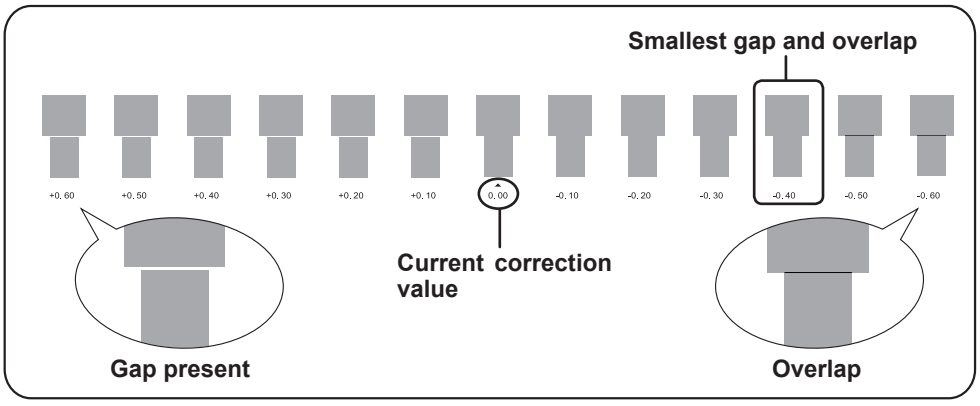
Current correction value

Value to be set

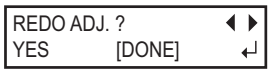
Use ▲ ▼ to set the correction value.
Press ENTER to enable the setting.

To decide a Correction Value

Select the value to make the upper/lower rectangular gap and overlap smallest.



❹



[To confirm again / adjust again]
Press ◄ to select [YES].
Press ENTER to enable the setting.
The test pattern of feed correction is output again. Go back to the procedure ❸ and set again.

[To go to the next after correction is completed]
Press ► to select [DONE].
Press ENTER to enable the setting.

For the individual setting method of this setting item and the description, refer to page 111 "Alleviating Horizontal Bands and the Like (feed correction function)."

To cancel the setting

Procedure

1. **Press (MENU) during the setting.**
2. QUIT SETTING? ◀ ▶
   [YES] NO ↵

   Press (◀) to select [YES].
   Press (ENTER).

   W XXXmm

   The screen returns to the screen shown at the left.
   By selecting [NO], the screen returns to the screen displayed when you pressed (MENU).

3. Performing the correction for misalignment in bidirectional printing

POINT!

This machine prints by the bidirectional mode (in which the print heads perform printing during both their outbound pass and return pass). This printing method is called "Bidirectional Printing." This method offers the advantage of being able to shorten output times, but subtle misalignment occurs during the outbound and return passes. The procedure to correct this and eliminate misalignment is "Bidirectional Correction."

1. ADJUST BI-DIR ◀ ▶
   [SET] NEXT ↵

   Press (◀) to select [SET].
   Press (ENTER) to enable the setting.
   The test pattern of bidirectional correction is output.

2. INPUT
   ADJ. VALUES ↵

   When the left figure is displayed, press (ENTER).

3. ADJUST BI-DIR ▲▼
   0 ▶ -6 ↵

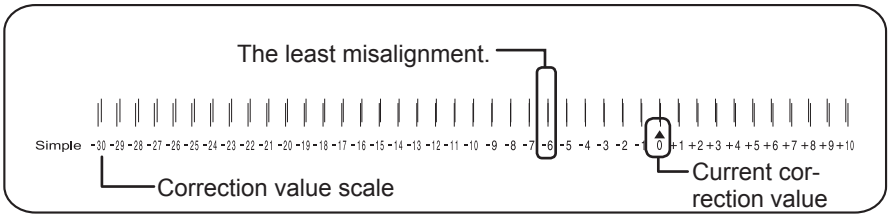
   Use (▲) (▼) to set the correction value.
   Press (ENTER) to enable the setting.

Current correction value

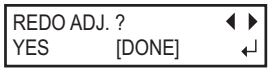
Value to be set

To decide a Correction Value

Choose the value that produces the least misalignment of 2lines.


The least misalignment.
Simple -30 -29 -28 -27 -26 -25 -24 -23 -22 -21 -20 -19 -18 -17 -16 -15 -14 -13 -12 -11 -10 -9 -8 -7 -6 -5 -4 -3 -2 -1 0 +1 +2 +3 +4 +5 +6 +7 +8 +9 +10
Correction value scale
Current correction value

❹



[To confirm again / adjust again]
Press ◄ to select [YES].
Press ENTER to enable the setting.
The test pattern of bidirectional correction is output again. Go back to the procedure ❸ and set again.

[To go to the next after correction is completed]
Press ► to select [DONE].
Press ENTER to enable the setting.

For the individual setting method of this setting item and the description, refer to page 110-111 "Correcting for Misalignment in Bidirectional Printing."

4. Saving the setting as preset

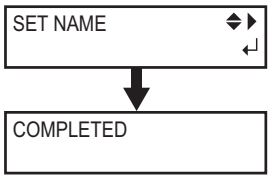
❶

Press ◄ to select [SAVE].
Press ENTER to enable the setting.
If you select [NEXT], the performed settings are retained. However, those settings are not saved as presets.

❷

Use ▲ ▼ to select the destination to save.
You can select one of NAME1 to 8.
Press ENTER to enable the setting.

❸



Use ▲ ▼ to select characters.
Use ► to move the next character.
Select the following characters in the same way.
You can enter up to15 characters.
Press ENTER to enable the setting.

For the individual setting method of this setting item and the description, refer to page 107 "Fully Utilizing Preset Function."

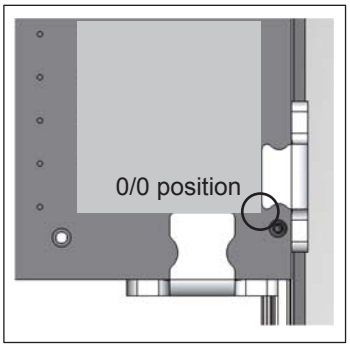
This completes the operation of the [MEDIA SETTING] menu.

Setting the Media Height

You can set the media height location at any location you prefer. (You cannot output if you do not set this.) Note, however, that this setting must be made for each media or change in media to ensure proper head height above media.

*Warning. "If media height is not set at the thickest point of irregular media, the heads may crash into the object, or the object could be severely damaged. Roland is not responsible for damage to any object setup incorrectly"

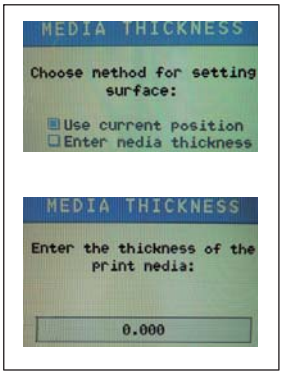
Automatic Procedure



1. **Load and position media on the table to the 0/0 position using the media registration brackets or at the desired position on the table.**
2. **Toggle the vacuum to ON** [VACUUM ON/OFF].
3. **Move the printer forward or backward to position the print area to the desired print location.**
   NOTE: Be sure to choose the thickest area of an irregular media.
4. **Press Shift** [SHIFT] **and Set Media Height** [Set MEDIA HEIGHT] **on Keypad.**
5. **Printer will automatically move backward to the proper sensor position, raise to the height measured and move back to the position of origin.**

Manual Procedure

1. **Load and position media on the table at the 0/0 position using the media registration brackets or at any desired position on the table.**
2. **Toggle the vacuum to ON** [VACUUM ON/OFF].
3. **Press Set Media Height** [Set MEDIA HEIGHT] **on Keypad.**
4. **The Menu will display a prompt for MEDIA THICKNESS.**
5. **Select ☒ Use current position and the printer will use to the last set media thickness.**
6. **Select ☒ Enter media thickness and enter the thickness desired of the media to printed (Example x.xxx). The printer will move to the entered height.**



Outputting

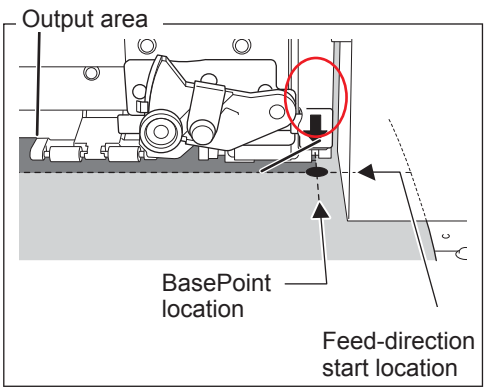
Setting the BasePoint Location

You can set the output-start location at any location you prefer. (You can output if you do not set this.) Note, however, that this setting must be made for each individual page because the setting returns to the default position when output is completed for each page.*

* Note, however, that the left and right positions are not restored to their defaults for test patterns.

Procedure

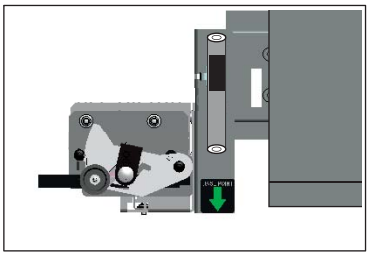
1. **Press 4 on the keypad or ◄ on the printer to move the printer out.**

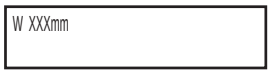
2. 

Press ▲ ▼ ◄ ► on either the keypad or printer to move the point of the arrow to the position where output begins, as shown in the figure on the left. The laser pointer will automatically activate, pointing parallel to the arrow on the print head.

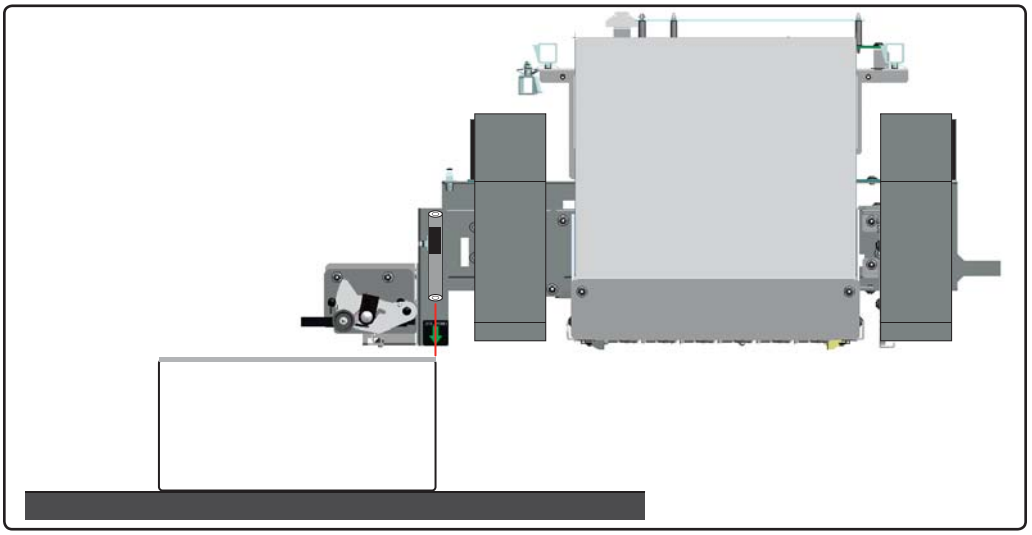
NOTE: The laser pointer has a built-in offset of and will position the printer to the selected position of the laser pointer.

3. **When the location is set, press BASE POINT on the keypad (BASE POINT) or on the printer.**



4. 

(BASE POINT) lights up, and setting is complete when the width that can be output at that location is displayed, as shown in the figure on the left.



Printing Tests and Normal Cleaning

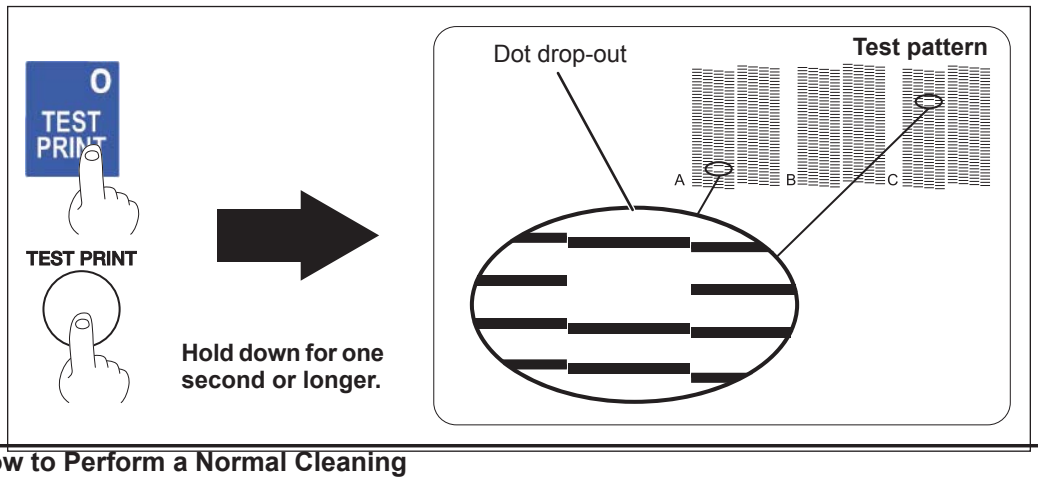
Before you carry out actual printing, we recommend performing a printing test to ensure no dot drop-out occurs. If dot drop-out occurs, perform cleaning of the print heads (Normal Cleaning).

How to Perform a Printing Test

Procedure

1. **Set the Output-start Location**
☞ P. 61, "Setting the Output-start Location"

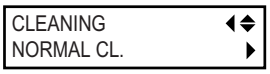
2. **Holding down 0 TEST PRINT on the keypad (TEST PRINT) on the printer for one second or longer.**
A test pattern is printed.



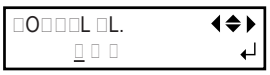
How to Perform a Normal Cleaning

Procedure

1. **Press CLEAN on the keypad or (CLEANING) on the printer.**

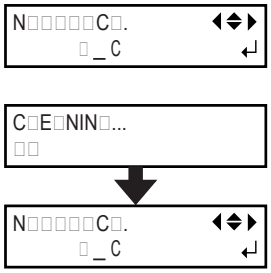
2. 

Press 6 or (►).

3. 

Press (◄) (►) to choose the group of print heads that is not to be cleaned.
Press (▲) (▼) to get rid of the group display.
Repeat this procedure to display the groups of only the print heads that require cleaning.
Of groups A through C, cleaning is performed only for the group displayed.

4

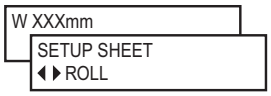


Press ENTER or ENTER.

Normal cleaning starts.

When it finishes, the screen shown in the figure appears again.

5



Press MENU ◄ in this order to go back to the original screen.

6 **Perform a printing test again to make sure the dot drop-out has been corrected.**

If the problem persists, try performing cleaning a second time. If the printer has been used for a long period, the problem may persist even after two or three-cycle cleaning. Then try cleaning using a different method.

☞ P.88, "When Normal Cleaning Is Not Effective"

If the printing-test results are difficult to interpret

Examine the results from different angles in a well-lighted location. Take advantage of reflected light to enable visual checking.

If you want to perform normal cleaning with all the print heads.

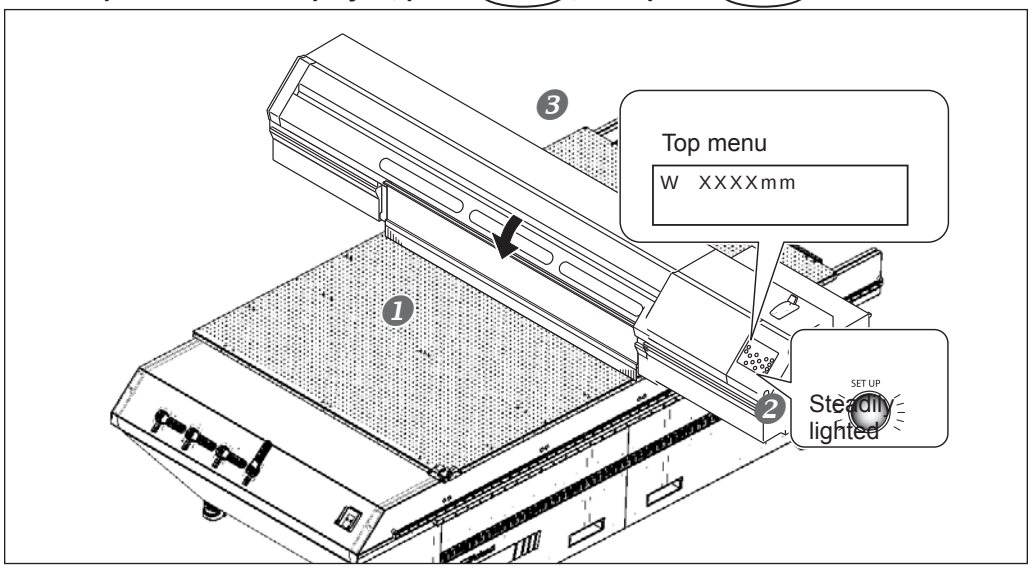
Hold down CLEAN or CLEANING for one second or longer. The normal cleaning for all the print heads starts.

Getting Ready to Receive Data from a Computer

When P.49, "Loading Media" and P.58, "Setup of Media" are completed, get ready to receive the data from a computer.

Procedure

1. **Close the front cover 1.**
2. **Make sure SET UP stays steadily lit.**
   If the light does not come on, press SET UP.
3. **Make sure the top menu is displayed.**
   If the top menu is not displayed, press MENU, then press ◄.



POINT! Output is not possible in these situations.

- The machine does not run when the front cover 1 is open.
- The machine will not operate if the front cover 2 is not attached.
- Do not open the front cover 1 or remove the front cover 2 during output. Doing so interrupts output.
- Data from the computer is not accepted when SET UP is dark.
- Data from the computer is not accepted when you are not at the top menu.

Starting Output

When the operation of page 64 "Getting Ready to Receive Data from a Computer" is completed, you can start output. To output, the following procedure is required.

① Creating Output Data

Create the output data using an application software such as Adobe Illustrator, CorelDraw or Adobe Photo-Shop. For information on how to create the data, refer to the documentation of your application software.

② Sending the Output Data to This Machine Using the Software RIP.

Use the included software RIP "Roland VersaWorks." For information on how to install and use Roland Versa-Works, refer to "Roland VersaWorks Quick Start Guide" and HELP of Roland VersaWorks. If using the white ink and gloss ink, refer to "White & Gloss Ink Guide."

IMPORTANT! Points that must be observed

- During output, never touch the media. Doing so may obstruct media feed or cause the media to rub against the print heads, which may result in a media jam or damage to the print heads.

POINT!

If ink runs out

When ink runs out, a warning beep sounds and a slot number of which ink runs out is displayed on the display screen.

☞ P. 78, "How to Replace Ink Cartridges"

Before you perform lengthy printing, check the amount of ink remaining in the ink cartridges.

Before you perform lengthy printing, check the amount of ink remaining in the ink cartridges. When ink runs out and printing is paused, the coloring at the seam may be altered when printing resumes.

☞ P. 77, "Checking for Remaining Ink"

When performing output involving pullback movement, make sure to wipe away any grime from the pinch rollers.

If the pinch rollers are dirty when performing output involving pullback movement, an imprint from the pinch rollers may be left behind.

Pausing and Canceling Output

You can pause and cancel output before it finishes. However, a horizontal stripe is produced at the location where output was stopped. We do not recommend resuming output.

Procedure

1 **Press PAUSE or PAUSE before output finishes.**

This pauses the output operation.

2 **Press PAUSE again to resume output.**

To cancel the output, go the next Procedure without pressing PAUSE.

3

When the screen shown in the figure appears, hold down SET UP for one second or longer.

This cancels the output operation.

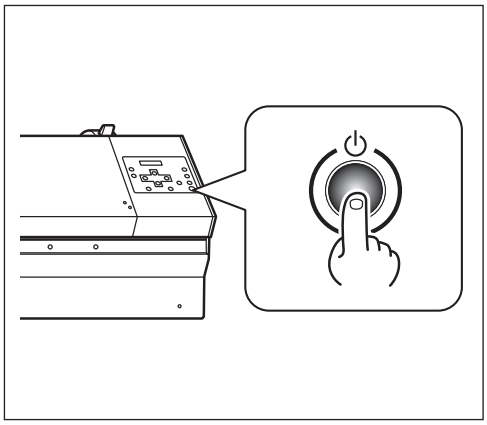
4 **Stop sending the output data from the computer.**

Switch Off

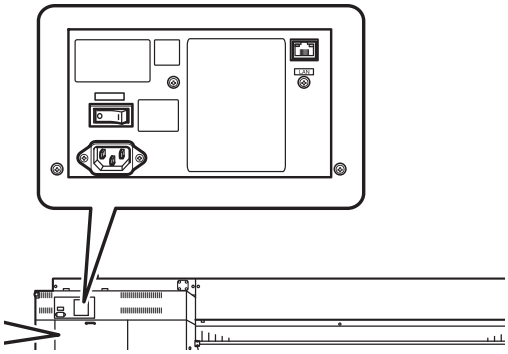
Switch Off

Procedure

❶ **Hold down the sub power button for one second or longer.**
The sub power is turned off. Perform this process after output is finished.



❷ **Turn off main power button on the back side of printer.**
The sub power is turned off. Perform this process after output is finished.



❸ **Once power is off on the printer, it is SAFE to turn off main power on the LEJ-640FT located on printer/table's electrical box.**

IMPORTANT!

Leave the main power switched on at all times.
Never switch off the main power. By switching on the main power, the automatic maintenance function is carried out periodically. If the automatic maintenance is not carried out, it may result in breakdown of this machine such as breakdown of the print heads.

Never switch off the main power or unplug the power cord suddenly while operation is in progress.
Switching off the main power or unplugging the power cord suddenly while operation in progress may damage the print heads. Be sure to first switch off the sub power. If the main power is accidentally switched off, immediately turn the power back on.

Chapter 3
Using The User Modes

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Conditions of User Modes on the Keypad 69
Output with Single Mode 70
Output with Multi Mode.....71
Output with Layer Mode 72

The User Modes on the Keypad

Features of the User Modes

The User Modes make it possible to perform output features defined as Single, Multi and Layered Modes to the LEJ-640FT while the jobs are automatically placed in pre-determined locations. This makes possible operations at the table which assist with the productivity of multiple prints or layered output.

About Single Mode

In Single mode, the printer processes each job individually. The machine will print each individual job file wherever the machine is homed, wherever the base point is set, or wherever the Return to Origin location is established from VersaWorks software. The next job will start at the ending point of the first job, the Return to Origin location, or a new Set Base Point set up by the user.

About Multi Mode

In Multi mode, the printer processes job files sequentially. The machine will print each individual job file wherever the machine is homed, but will return to the previously established Origin or Base Point.

For Example: If the user sends 10 jobs to the printer, then he or she can expect the following:

1. The first job will begin at the base point or at the origin established by the user and will execute.
2. The printer will end the job file and return to the base point or origin location.
3. The user will turn off the vacuum and remove the media.
4. The user will reset other media to the current base point or origin location.
5. The keypad will prompt the user to press Enter, which creates the command to begin the sequential print.
6. The user will press Enter once the job file is ready to be processed.
7. The vacuum will automatically restart.
8. The keypad will prompt the operator to either complete an automatic head height detection or use the current location.
9. The user will select the proper head height.
10. The second job will begin.

About Layered Mode

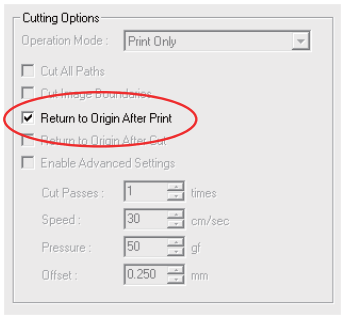
In Layer mode, the printer will operate in the same manner as in Multi mode but will move to a preset height between each application of the file. Layer mode is most ideally suited for special effects (i.e., gloss, white, overprint). If the user were to send 5 prints of special effects in layer mode, then he or she would expect that each sequential print would raise to the default height of 0.15" above the previous print. The user may press Shift and Layer Mode to define the height of automatic increase in between selected prints (e.g., 0.25") for a value other than the default. There is no limit for the automatic increase distance, but raising the value too high (e.g., above 2mm) will result in poor print quality.

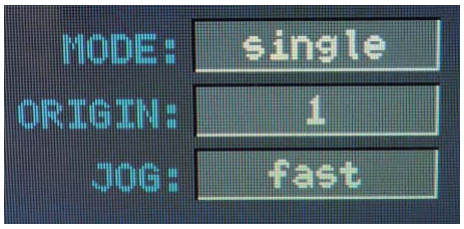
The printer counts the total number of prints in Layer mode but cannot discern the number of prints per job. If the user wants to zero out the total prints, then he or she will need to switch to a different mode (e.g., Multi) and then switch back to Layer mode to restart the count.

Conditions of the Modes on the Keypad

Performing Output with Single Mode

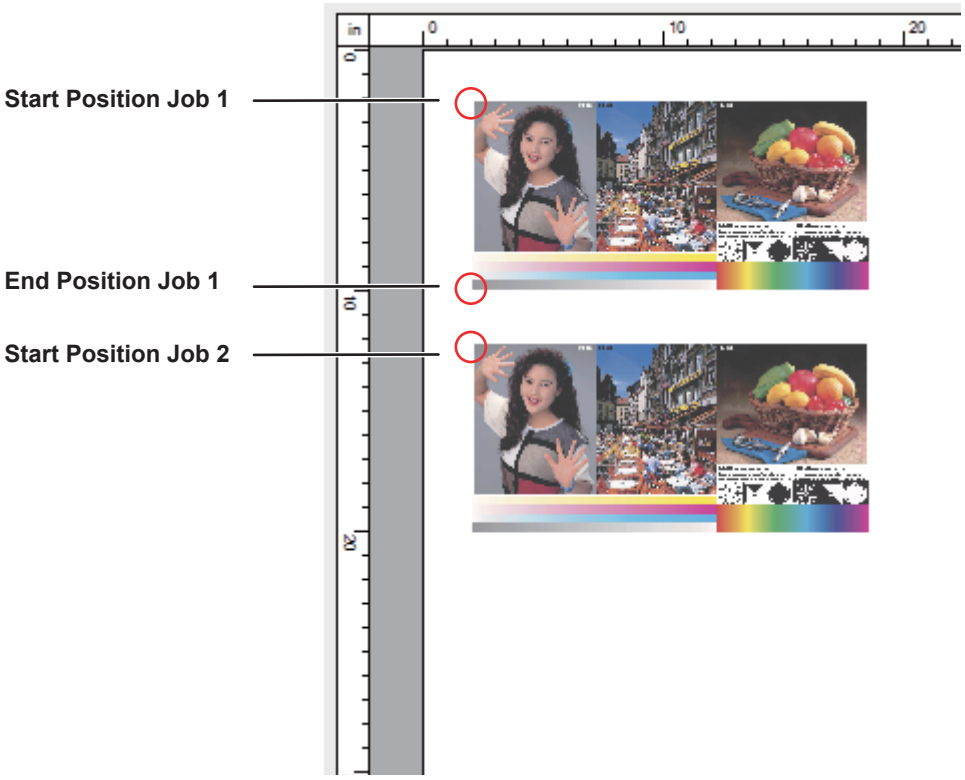
In to SINGLE MODE Single mode, the printer processes each job individually and when finished will either Return Origin After Print if selected in VersaWorks or at the print end location on the media.





The machine will print each individual job file wherever the machine is homed, wherever the base point is set, or wherever the Set Origin location is established from VersaWorks software.

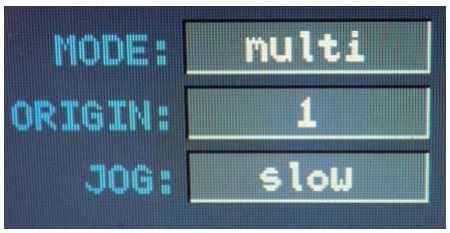
The next job will start at the ending point of the first job, the Return to Origin location, or a new Set Base Point set up by the user.



Performing Output with Multi Mode

MULTI MODE

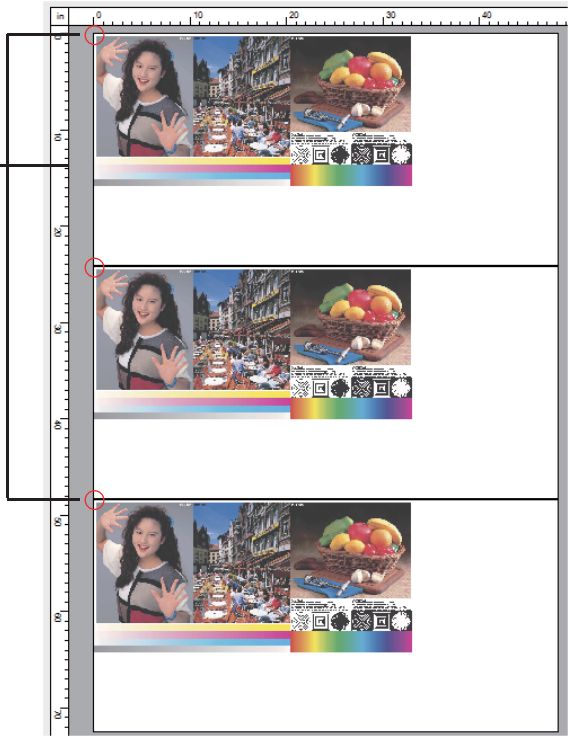
In Multi mode, the printer processes job files sequentially. The machine will print each individual job file wherever the machine is homed, but will return to the previously established Origin or Base Point. Mulit Mode is designed to make repeated or sequential prints easier or more prodcutive.



For Example: If the user sends 10 copies to the printer, the user can expect the following:

1. The first job will begin at the base point or at the origin established by the user and will execute.
2. The print will finish and return to the base point or origin location.
3. The user will turn off the vacuum and remove the media.
4. The user will reset other media to the current location.
5. The keypad will prompt the user to press Enter, which creates the command to begin the sequential print.
6. The user will press Enter once the job file is ready to be processed.
7. The vacuum will automatically restart.
8. The keypad will prompt the operator to either complete an automatic head height detection or use the current location.
9. The user will select the proper head height.
10. The second job will begin.
11. In the Info Dialogue box a sequential counter will automatically provide the number of prints printed.

Each print starts and returns to the home origin (0/0) location or a specific location "set" by user as base point. Each consecutive print, a prompt will ask to remove and place new media. If the vacuum is turned it can be turned on or it will go on automatically prior to the start of the next print.



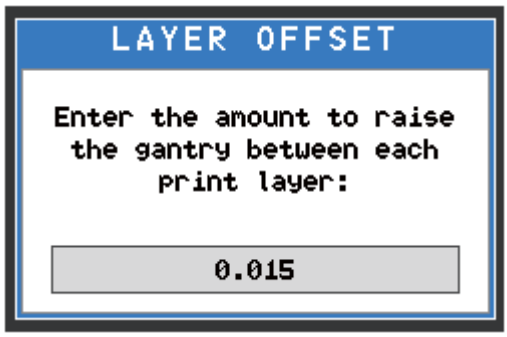
Performing Output with Layered Mode

LAYER MODE

In Layer mode, the printer will operate in the same manner as in Multi mode but will raise to a preset height between each application of the file. Layer mode is ideally suited for special effects such as gloss, emboss and white overprints. If the user were to send 5 prints of special effects in layer mode, then he or she would expect that each sequential print would raise to the default height of 0.015" above the previous print. The user may press Shift and Layer Mode to define the height of automatic increase in between selected prints (e.g. 0.015") for a value other than the default. There is no limit for the automatic increase distance, but raising the value too high (e.g., above 2mm) will result in poor print quality.

The printer counts the total number of prints in Layer mode but cannot discern the number of prints per job. If the user wants to zero out the total prints, then he or she will need to switch to a different mode (e.g., Multi) and then switch back to Layer mode to restart the count.

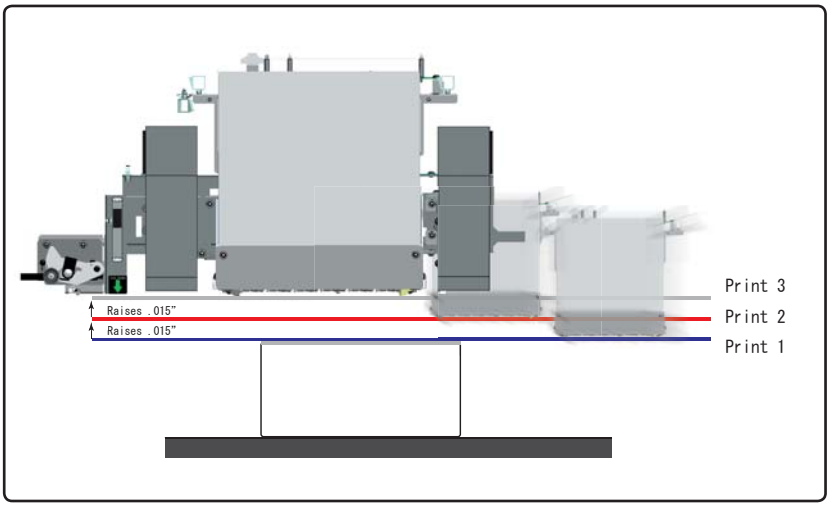
Press SHIFT + LAYER MODE and the LAYER OFFSET dialogue box will prompt to ENTER the vlaue desired to raise between each pass.



After each print, the Print Carriage will automatically raise the value entered (0.015").

Note: For Gloss prints, the printer will raise between each print and for Embossing the printer will raise after every other pass.

(Emboss uses two passes to complete one layer.)



Chapter 4
Maintenance:

For always using the printer in the best condition

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Checking for Remaining Ink and Replacing Cartridges

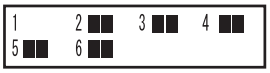
Checking for Remaining Ink

Procedure

1. **Press MENU.**

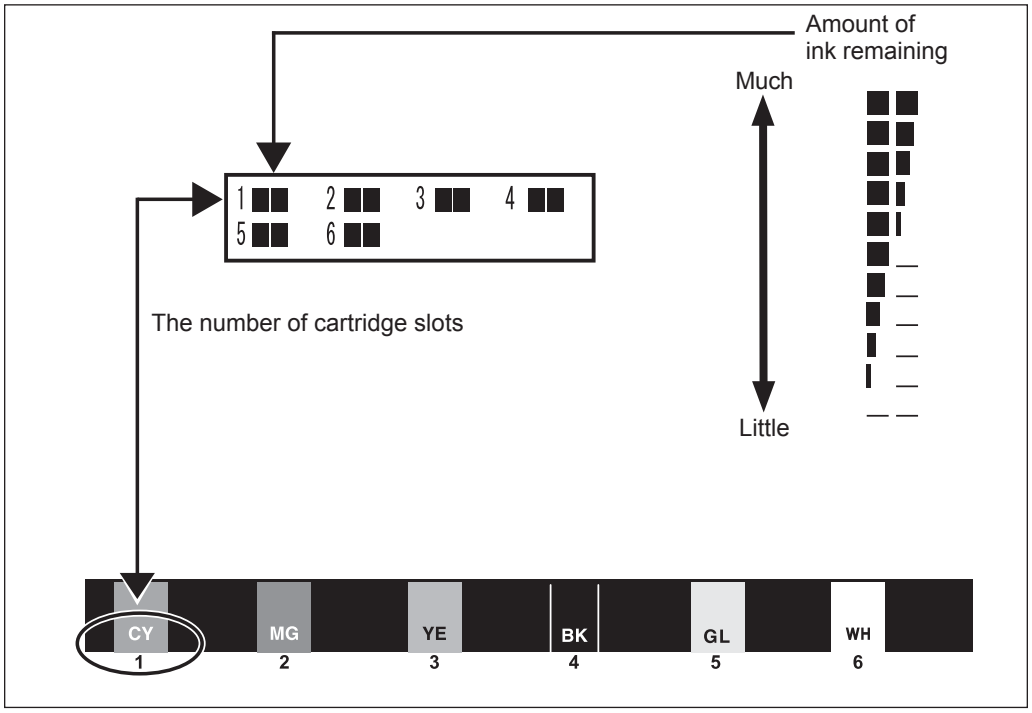
2.

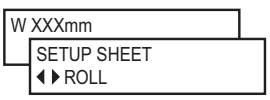
Press ▲ several times until the screen shown on the left appears.
Press ►.



■ indicates the amount of ink remaining. When there are more ■, the amount of ink remaining is larger.

*** The display shows an approximate guide to the amount of remaining ink. It may differ somewhat from the actual amount remaining.**



3. 

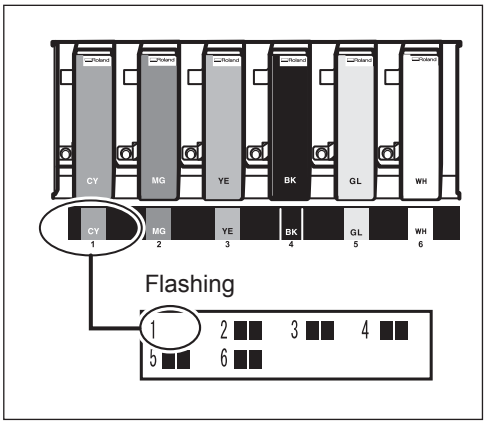
Press MENU ◄ in this order to go back to the original screen.

How to Replace Ink Cartridges

When ink runs out, a warning beep sounds and printing pauses (unless the default settings have been changed). Pull out the empty cartridge and insert a new one. Printing resumes.

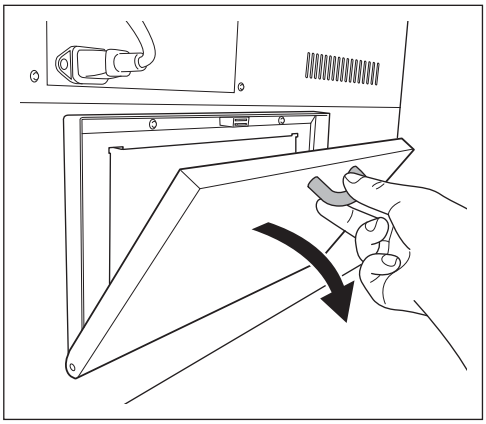
Procedure

1



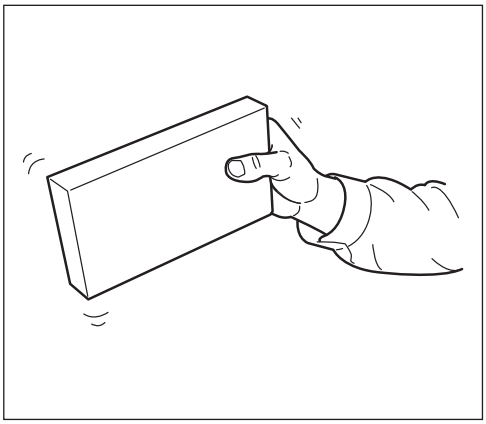
Check the number flashing on the screen.
The ink at the flashing cartridge slot number is running out.

2

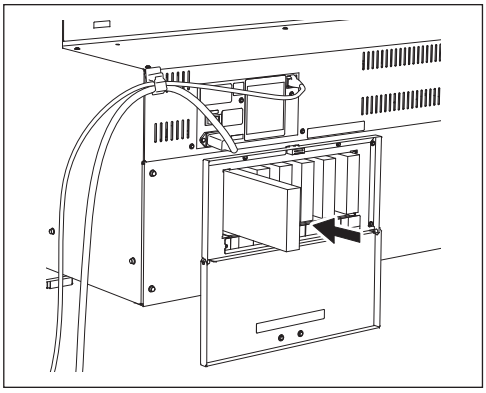


Open the ink cartridge cover.

3



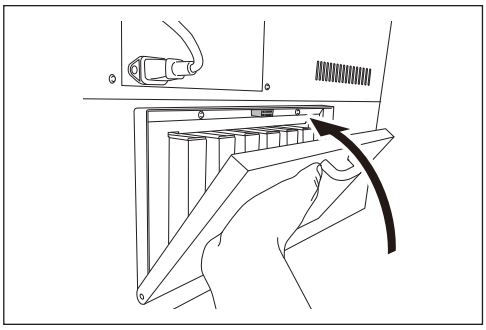
Shake the ink cartridge of the same type and color to replace.

4 

Pull out the empty ink cartridge and immediately insert the new one.

POINT!

- Keep the labeled side face up.
- Insert and remove slowly, one at a time.
- Make sure the cartridge is inserted completely.

5 

Close the ink cartridge cover.

IMPORTANT! Important notes on replacing cartridges

- Make sure that the ink cartridge cover is always closed except when absolutely necessary, such as when you are replacing ink cartridges. The ink inside the cartridges will become hardened, and it may cause the printer to malfunction.
- Be sure to replace with an item of identical type.
- Never use an ink cartridge which has already been used in other machines even if it is of the identical type.
- Never mix items of different types.
- Never allow the machine to stand with an ink cartridge removed. The print heads may become clogged.
- Never insert or remove a partially used ink cartridge.
- Never remove an ink cartridge suddenly while the printer is in operation.

⚠WARNING **Never store ink, cleaning liquid, or discharged fluid in any of the following locations.**

- Any location exposed to open flame
- Any location where high temperature may occur
- Near bleach or any other such oxidizing agent or explosive material
- Any location within the reach of children

Fire may be a danger. Accidental ingestion by children may pose a health hazard.

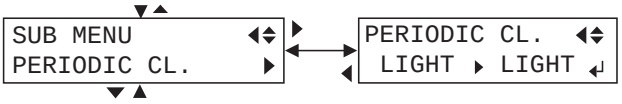
Automatic Maintenance Feature

Automatic Maintenance Feature and Notes

This machine is provided with a feature that automatically performs maintenance on a periodic basis. Because this performs operations that are intended to keep the print heads from drying out, be sure to observe the following matters.

- **Leave the general and main power on at all times.**
- **Never leave the front cover 1 open for long periods.**
- **After finishing making the settings for the various menu items, go back to the top menu.**

- **Turn on Periodic Cleaning**



This menu is to select the type of periodic cleaning which is automatically performed during printing.
Options: WIPE / LIGHT / NORMAL / MEDIUM Default: NORMAL

WIPE: Wiping and flushing only
LIGHT: Wiping and light evacuation (lighter than regular cleaning) only
NORMAL/MEDIUM: The regular cleanings that can be executed from the control panel

Cleaning period can be set up in PERIODIC CL. menu of the user menu.

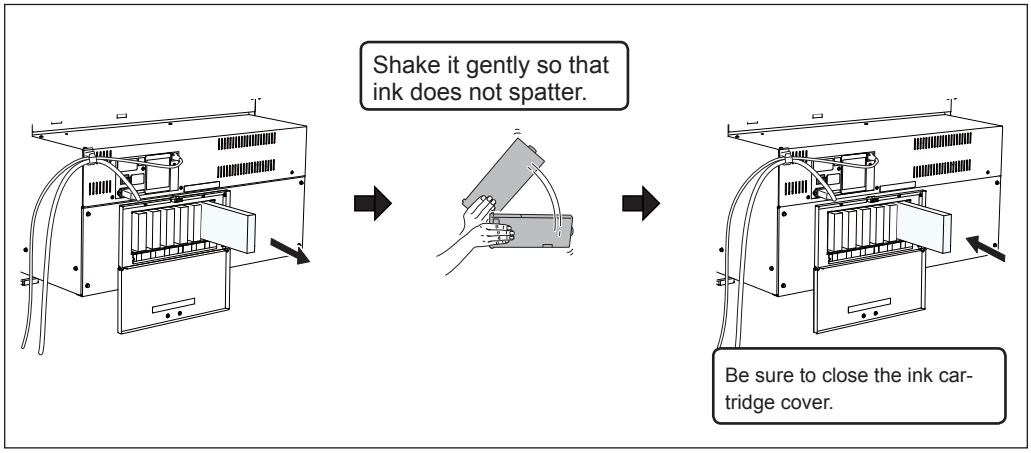
Maintenance that Should Be Performed Daily

Maintenance of Ink Cartridges

Be sure to perform the following tasks. The ink contains ingredients that have the property of becoming deposited. Particularly, the white ink contains ingredients that are highly likely to get deposited, and the settled components may get hardened and cause troubles including malfunctions of the machine if it is left untouched for a certain time.

- **Shake the new ink cartridge gently before setting it in.**
- **Remove only the white ink cartridge once, shake it gently, and set it in before starting the operation for the day.**

☞ P. 105, "The Concentration and Dot Drop-Out of the White Ink"



Disposing of Discharged Ink

CHECK DRAIN BOTTLE	The drain bottle collects discharged fluid. Dispose of collected material before the bottle becomes full. The message shown in the figure appears when a certain amount of discharged fluid has collected in the bottle. Follow the procedure below to discard the discharged fluid.

Procedure

1. CHECK
DRAIN BOTTLE

   When the message shown in the figure appears, press ENTER.

2. **Press MENU.**

3. MENU ◀▲▼
SUB MENU ▶

   Press ▼ several times to display the left figure.
   Press ► and then ▲.

4. SUB MENU ◀▲▼
MAINTENANCE ▶

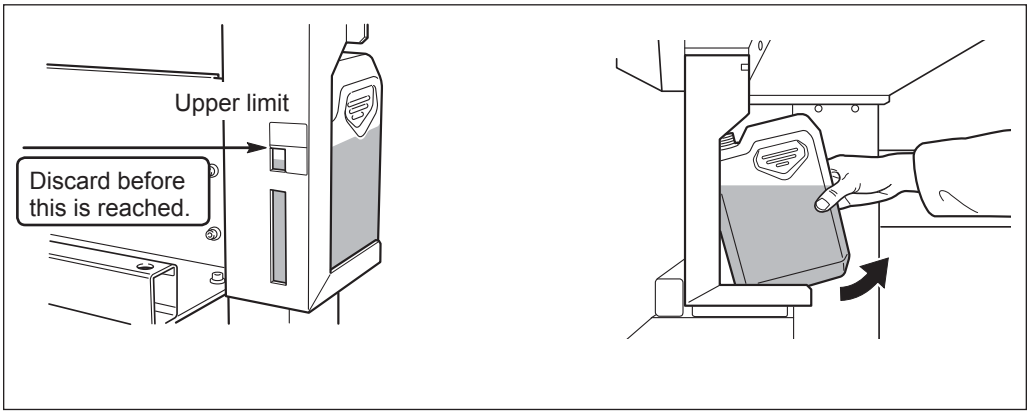
   Press ► and then ▲.

5. MAINTENANCE ◀▲▼
DRAIN BOTTLE ↵

   Press ENTER.

6. EMPTY ◀
DRAIN BOTTLE ↵

   When the screen shown on the left appears, detach the bottle, discard the discharged fluid to empty it.



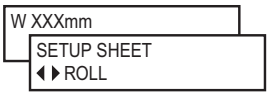
⚠CAUTION **Before you detach the drain bottle, be sure to wait for the screen to display "EMPTY DRAIN BOTTLE."**
Failing to follow this procedure may cause discharged fluid to flow out of the tube and spill, soiling your hands or the floor.

❼

Attach the emptied drain bottle to the machine.
Press ENTER.

❽

Press ENTER.

❾ 

Press MENU ◄ in this order to go back to the original screen.

⚠WARNING **Never place discharged fluid near open flame.**
Doing so may cause fire.

⚠CAUTION **To store discharged fluid temporarily, place it in the included drain bottle or in a durable sealed container such as a metal can or polyethylene tank, and cap tightly.**
Any spillage or vapor leakage make cause fire, odor, or physical distress.

Store discharged fluid in a location not exposed to direct sunlight.
When temporarily storing discharged fluid in the included drain bottle, keep the drain bottle out of direct sunlight. Otherwise the discharged fluid may harden, making the drain bottle unusable.

Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.
Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing so may have an adverse impact on the environment.

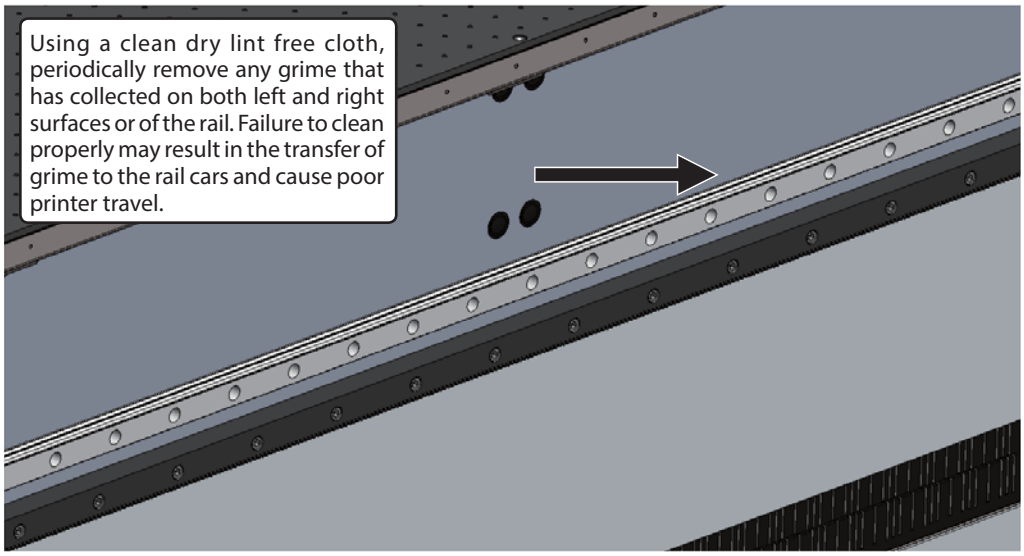
Cleaning

⚠WARNING **Never use gasoline, alcohol, thinner, or any other flammable material.**
Doing so may cause fire.

Wipe away any buildup of ink or grime on the media path and other locations as daily cleaning. In particular, the pinch rollers, grit rollers, platen, and the rubber cover on the front cover 2 are likely to get a build-up of grime. Clean by wiping with a cloth moistened by neutral detergent diluted with water then wrung dry.

POINT!

- This machine is a precision device, and is sensitive to dust and dirt. Perform cleaning on a daily basis.
- Never attempt to oil or lubricate the machine.


Using a clean dry lint free cloth, periodically remove any grime that has collected on both left and right surfaces or of the rail. Failure to clean properly may result in the transfer of grime to the rail cars and cause poor printer travel.

About Care and Maintenance of Print Heads

Care of the print heads is essential to ensuring optimal printing at all times. There are daily care and periodic care.

Daily Care and Maintenance

- Normal cleaning
  It is recommended to perform the normal cleaning before daily operation.
  ☞ P. 67, "Printing Tests and Normal Cleaning"

Periodic Care and Maintenance

- Medium cleaning/Powerful cleaning
  Perform the medium cleaning or powerful cleaning when the problems such as dot drop-out are not cleared up by the normal cleaning.
  ☞ P. 83, "Medium/ Powerful Cleaning"
- Manual Cleaning
  Based on your frequency of use, perform the manual cleaning periodically.
  ☞ P.89, "Performing Manual Cleaning"
- Circulation of White ink
  Perform the circulating ink when concentration of the white ink to decrease.
  ☞ P 96, "Restoring White Ink Concentration"
- White Ink Replacement
  Perform the white ink replacement when the dot drop-out cannot be cleared by conducting the cleaning features (including the normal, medium, and powerful cleaning) or the manual cleaning.
  ☞ P. 97, "When the Dot Drop-Out Cannot be Cleared"

* The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use. Purchase them from your authorized Roland DG Corp. dealer.

When Normal Cleaning Is Not Effective

Medium/ Powerful Cleaning

When the dot drop-out cannot be cleared by the normal cleaning ("Printing Test and Normal Cleaning" on page 67), perform a more powerful cleaning, a "medium cleaning," twice or three times. If the condition is not improved, try the even more forceful "powerful cleaning."

> **POINT!**
>
> The medium cleaning consumes more ink than the normal cleaning. The powerful cleaning consumes more ink than the medium cleaning. Because the print heads are prone to get damaged if these cleanings are conducted too frequently, do not perform such cleanings more than necessary.

Procedure

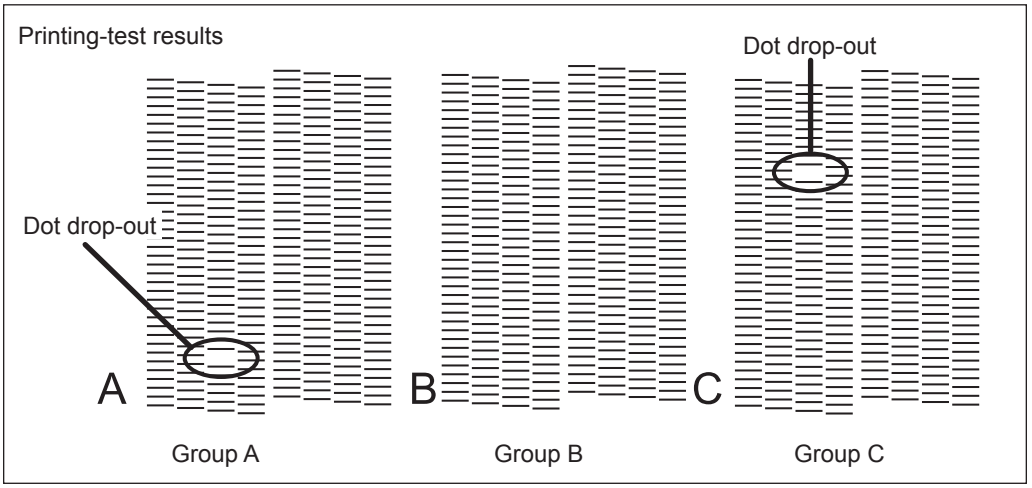
1. **Press CLEANING.**

2. CLEANING
   MEDIUM CL. ▶

   Press ▼ or ▲ and select "Medium."
   When "Medium" is not effective, select "Powerful."
   Press ►.

3. MEDIUM CL.
   A B C ↵

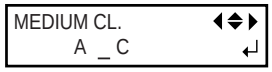
   Press ◄ ► to choose the group of print heads that is not to be cleaned.
   Press ▼ ▲ to get rid of the group display.
   Repeat this procedure to display the groups of only the print heads that require cleaning.



If the printing-test results are difficult to interpret

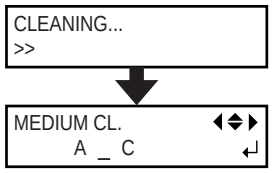
Examine the results from different angles in a well-lighted location. Take advantage of reflected light to enable visual checking.

4



Press (ENTER) **.**

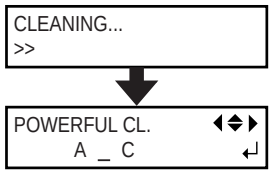
5



If you Chose "MEDIUM CL."
The screen shown in the figure appears, then cleaning starts.

When it finishes, the screen shown in the figure appears.

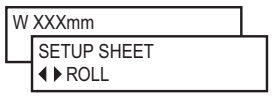
If You Chose "POWERFUL CL."
Check the drain bottle.
If the amount of discharged fluid is near the upper-limit line, then remove the bottle, discard the collected fluid, and reattach the bottle.
Press (ENTER) **.**



The screen shown in the figure appears.

When it finishes, the screen shown in the figure appears.

6



Press (MENU) (◄) **in this order to go back to the original screen.**

Maintenance that Should Be Performed More Than Once a Month

When Manual-Cleaning Becomes Necessary

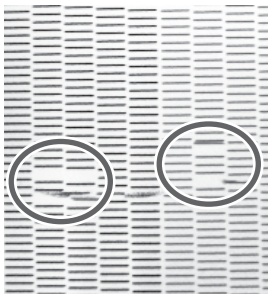
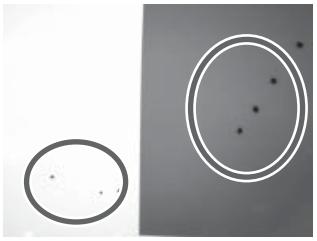
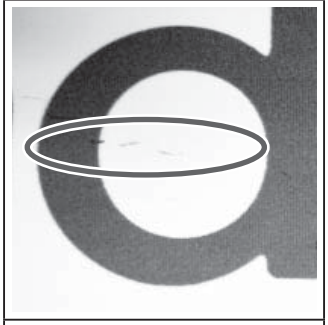
Perform The Manual Cleaning More Than Once a Month.

To keep the stable output condition at all times, perform the manual cleaning more than once a month.

The Manual Cleaning is Recommended When The Following Symptoms Occur.

It is recommended to perform the manual cleaning when any of the symptoms given below occurs and it cannot be solved by the automatic cleaning functions such as the normal cleaning.
For your information, replacement of the wiper is also effective to improve the symptoms.

☞ P. 96, "Replacing the Wiper"

Dot drop-out or deflection	Ink drips	Dragging dirt
		
Flaws in the dot pattern are caused by dust on the print heads.	Ink that has adhered to a dirty or dusty print heads drips onto the media.	When dirt or dust accumulates on the print heads it can interfere with image quality.

* When the cleaning stick and cleaning liquid for the manual cleaning runs out, place an order for them with your authorized Roland DG Corp. dealer.
* The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use. Purchase them from your authorized Roland DG Corp. dealer.

About Cleaning of the UV Emitter

Clean the emitter area (glass side) of UV emitter, when you perform the Manual Cleaning. Use the commercially glass cleaner for cleaning. Never use the included cleaning liquid. Otherwise, UV emitter may be damaged.

Performing Manual Cleaning

IMPORTANT!

Important notes on this procedure

- For the manual cleaning, the included cleaning liquid, cleaning stick and the commercially available glass cleaner are necessary. Please prepare them in advance.
- Before attempting this operation, remove any media.
- To prevent the print heads from drying out, finish this procedure in 10 minutes or less. A warning beep sounds after 10 minutes.
- Never use any implement other than the included cleaning stick. Cotton swabs or other lint-producing items may damage the print heads. If you use up the cleaning stick, purchase a new one from your authorized Roland DG Corp. dealer.
- Use one cleaning stick per cleaning session, then discard the stick after use. Reusing cleaning sticks may reduce printing quality.
- Do not put the cleaning stick used for cleaning into the cleaning liquid. It will deteriorate the fluid.
- Never rub the nozzle surface of the print heads.
- Stroke the sponges very gently, applying as little pressure as possible. Never rub, scrape, or crush them.
- Use the commercially glass cleaner, when you clean the emitter area (glass side) of UV emitter. Never use the included cleaning liquid. Otherwise, UV emitter may be damaged.

When a warning beep sounds during cleaning

- A warning beep sounds after 10 minutes. At this time, stop work, attach the side cover and the maintenance cover, then close the front cover 1. Press ENTER to quit the manual-cleaning menu. After that, restart the procedure from the beginning.

⚠CAUTION **Be sure to perform operations as specified by the instructions above, and never touch any area not specified in the instructions.**
Sudden movement of the machine may cause injury.

1. Change to the print-head manual-cleaning menu.

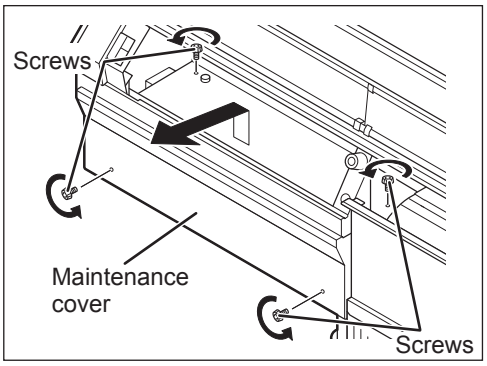
1. **Remove any media.**
2. **Press MENU or press the Maintenance and the printer will automatically jump to step 5.**
3. MENU / SUB MENU — **Press ▼ several times until the screen shown on the left appears. Press ► and then ▲.**
4. SUB MENU / MAINTENANCE — **Press ►.**

❺ MAINTENANCE ◀◆
CLEANING ↵

Press ENTER .

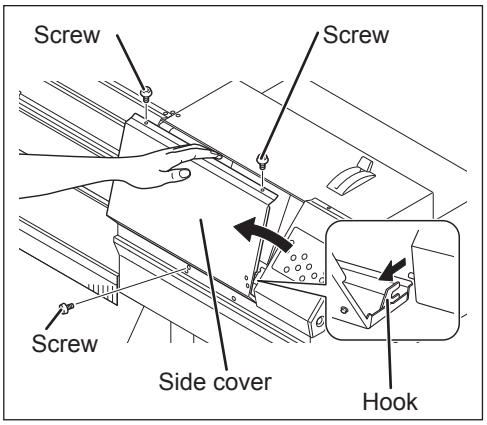
❻ OPEN MAINTE- ◀
NANCE COVER ↵

Open the front cover 1 and remove the maintenance cover.
Close the front cover 1 and press ENTER .
The print-head carriage moves to the left side of the machine.

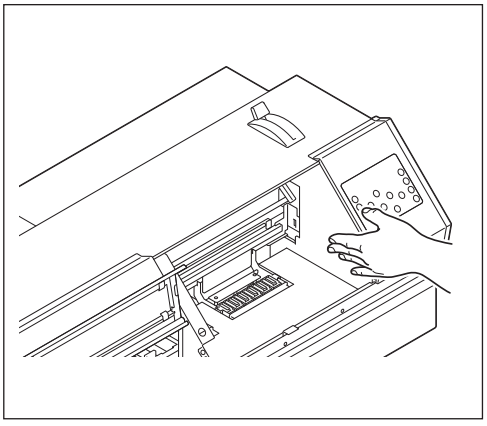


❼ OPEN SIDE
COVER

When the screen shown on the left appears, open the side cover.



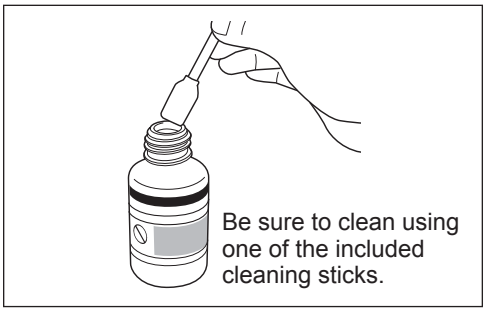
❽



Touch the location shown in the figure to discharge any static electricity.

❾ FINISHED? ↵ **Preparations are complete when this screen appears.**

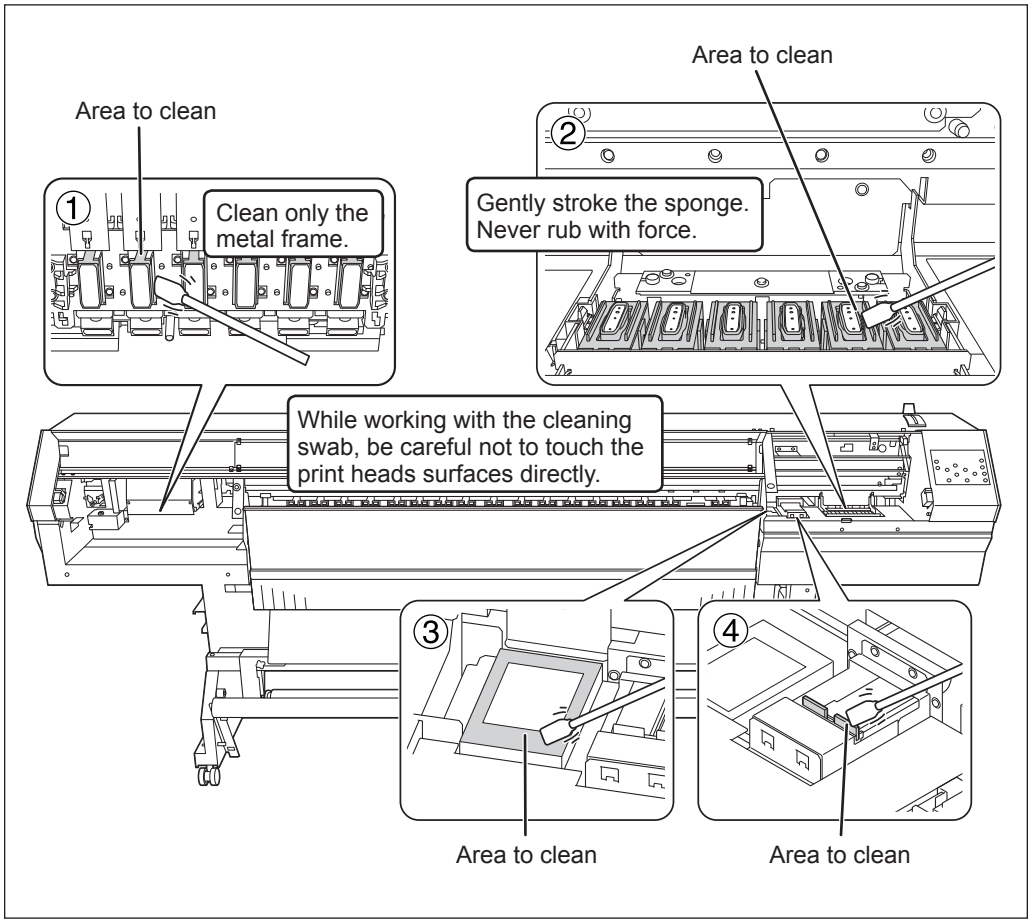
2. Clean using the cleaning stick.

❶ 

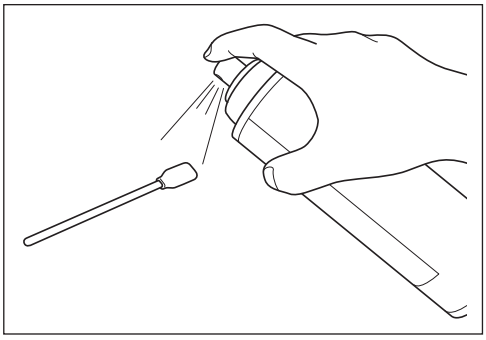
Moisten the cleaning stick with the cleaning liquid.

❷ **Perform cleaning in the sequence shown in the figure below.**

Be especially careful to clean away any fibrous dust (lint).


Area to clean
Area to clean
1
Clean only the metal frame.
2
Gently stroke the sponge. Never rub with force.
While working with the cleaning swab, be careful not to touch the print heads surfaces directly.
3
4
Area to clean
Area to clean

❸

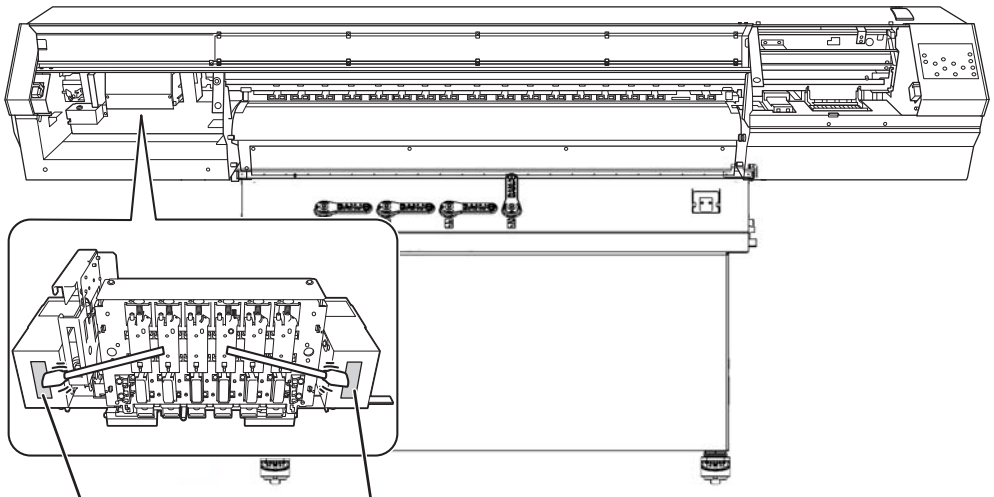


Apply commercially available glass cleaner to the cleaning stick.

Use a new cleaning stick.

❹ **Clean the locations shown in the figure.**

Be especially careful to clean away any fibrous dust (lint).



Area to clean
The UV emitter area
(glass side)

Area to clean
The UV emitter area
(glass side)

Caution

- While working with the cleaning swab, be careful not to touch the print heads surfaces directly.
- Never use the included cleaning liquid. Otherwise, UV emitter might get broken/(may be damaged).

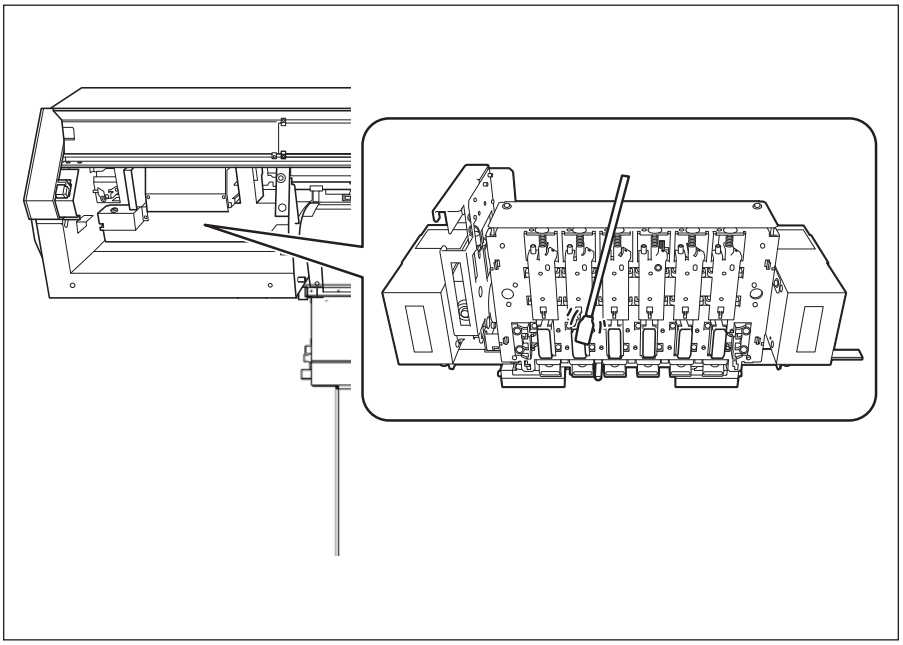
POINT! Cleaning of the print heads surface as an emergency measure

When dot drop-out and/or dot deflection is not improved even if cleaning is performed several times, you can clean the print heads surface as an emergency measure. Since the print heads surface (nozzle surface) has an extremely delicate mechanism, make sure to perform the operation carefully and deliberately.

Note that this operation is an emergency measure. It may damage defect-free parts depending on the symptom, deteriorating it. If you have any questions, contact your authorized Roland DG Corp. dealer.

Procedure

1. **Moisten the cleaning stick with the cleaning liquid.**
2. **Softly press the cleaning stick to the print heads surface (nozzle surface).**
   Press it gently and softly so that the print heads nozzle is permeated with the cleaning liquid. Never rub the stick on the surface and press it forcibly.

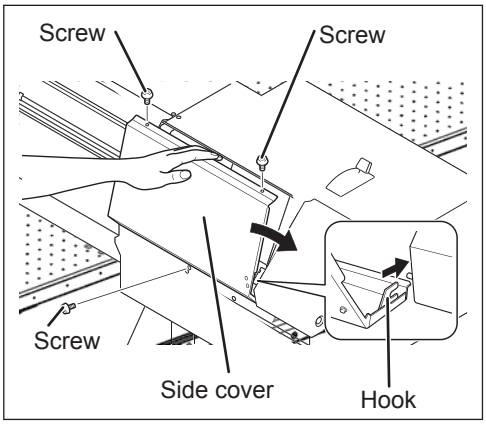


3. Quit the manual cleaning mode.

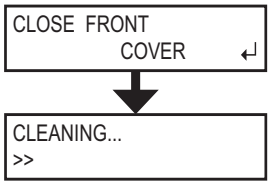
❶ **Press** ENTER **.**

❷

When the screen shown on the left appears, attach the side cover.
Press ENTER **.**



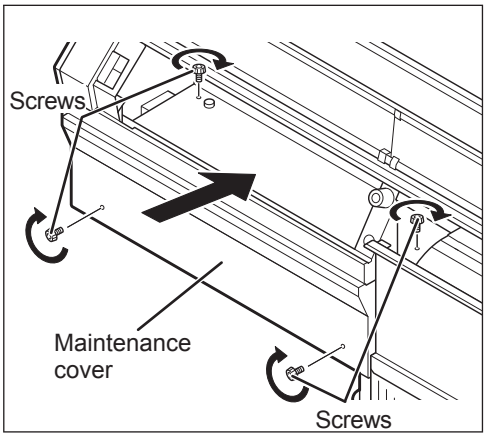
❸

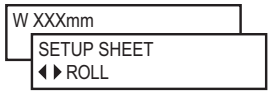


Close the front cover 1.
Press ENTER **.**
The print-head carriage moves to the right side of the machine.

❹

When the screen shown on the left appears, open the front cover 1, and then attach the maintenance cover.
Close the front cover 1.
Press ENTER **.**



❺ 

Press MENU ◄ in this order to go back to the original screen.

4. Perform a printing test to verify the results of the procedure.

Perform a printing test to check the results.

Perform cleaning using the machine's cleaning feature several times when necessary.

☞ P. 67, "Printing Tests and Normal Cleaning"

The Concentration and Dot Drop-Out of the White Ink

Restoring White Ink Concentration

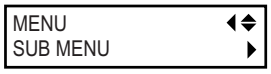
Prolonged use of this machine may cause the concentration of the white ink to decrease. This is because white ingredients in white ink easily precipitate. The "CIRCULATING INK" feature circulates the ink to eliminate white ink precipitation. However, this procedure requires some ink to be discharged, so you should not perform this procedure frequently.

IMPORTANT!

This function applies to the Version 1.50 or later of the printer firmware. For how to check the firmware version, refer to P. 142, "Viewing Information about the System of This Machine".

Procedure

1. **Press MENU.**

2. 

   Press ▼ several times until the screen shown on the left appears.
   Press ►.

3.

   Press ▲ several times until the screen shown on the left appears.
   Press ► and then ▲.

4.

   Press ►.

5.

   Press ENTER.
   Ink circulation starts.

When the Dot Drop-Out Cannot be Cleared

White ink may sometimes cause abnormal discharges including the dot drop-out even when the cleaning features (such as the normal, medium, and powerful cleaning) and the manual cleaning are performed. This can occur because the ingredients in white ink tend to settle, and may harden if allowed to stand for a lengthy time. If this happens, carry out the operations described below. This operation requires two cleaning cartridges.

IMPORTANT!

A large amount of ink will be discharged during this operation. Perform this operation only when dot drop-out cannot be cleared up even after performing cleaning using the cleaning function (normal, medium, or powerful) or manual cleaning.

☞ P. 90, "Maintenance that Should Be Performed Daily"
☞ P. 95, "When Normal Cleaning Is Not Effective"
☞ P. 85, "Maintenance that Should Be Performed More Than Once a Month"

Procedure

1 **Press (MENU).**

2

```
MENU
INK RENEWAL
```

Press (▲) several times until the screen shown on the left appears.
Press (ENTER).

3

```
CHECK
DRAIN BOTTLE
```

Discard the discharged fluid and attach the emptied bottle.
Press (ENTER).

4

```
REMOVE CARTRIDGE
1 2 3 4 5 6
```

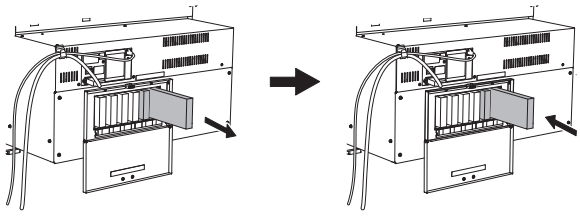
Number 5 and 6 flashes.

```
SET CL-LIQUID
1 2 3 4 5 6
```

Number 5 and 6 flashes.

```
RENEWING INK . . .
>>>>>>
```

① Open the ink cartridge cover.
② Remove the ink cartridges from slots 5 and 6.
③ Insert SOL INK cleaning cartridges into slots 5 and 6.

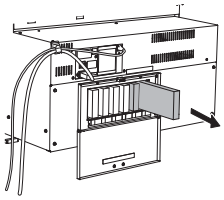


5

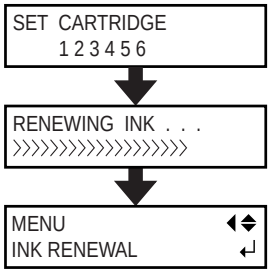
```
REMOVE CL-LIQUID
1 2 3 4 5 6
```

```
RENEWING INK . . .
>>>>>>>>>>>>
```

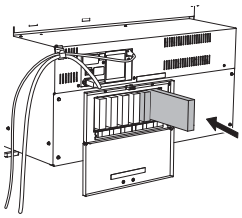
When this screen appears, pull out the SOL INK cleaning cartridges from slots 5 and 6.
Carry out steps **4** and **5** as many times as indicated by the on-screen messages.



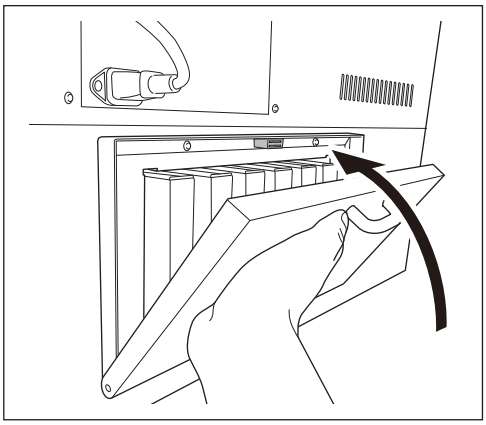
❻



When this screen appears, insert the ink cartridges into slots 5 and 6.

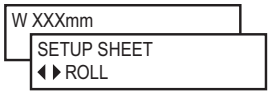


❼



Close the ink cartridge cover.

❽



Press MENU ◄ in this order to go back to the original screen.

Replacing Consumable Parts

Replacing the Wiper

The wipers are components that you use when cleaning the print heads. When the screen displays a message like the one shown, it means the item needs to be replaced. Replace with new items.
Regarding the purchase of the wiper, contact your authorized Roland DG Corp. dealer.

When a warning beep sounds during replacing the wiper.

A warning beep sounds after 10 minutes. At this time, stop work, attach the side cover. And then press ENTER to finish the wiper replacement menu. When the print-head protection operation finishes, restart the procedure from the beginning.

⚠CAUTION **Be sure to perform operations as specified by these instructions, and never touch any area not specified in the instructions.**
Sudden movement of the machine may cause injury.

1. Display the [REPLACE WIPER] menu.

❶

When the message shown in the figure appears, press ENTER.

❷ **Remove any media from the platen.**

❸ **Press MENU.**

❹

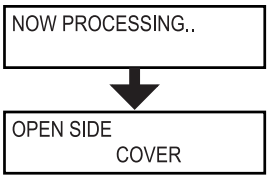
Press ▼ several times until the screen shown on the left appears.
Press ► and then ▲.

❺

Press ► and then ▼.

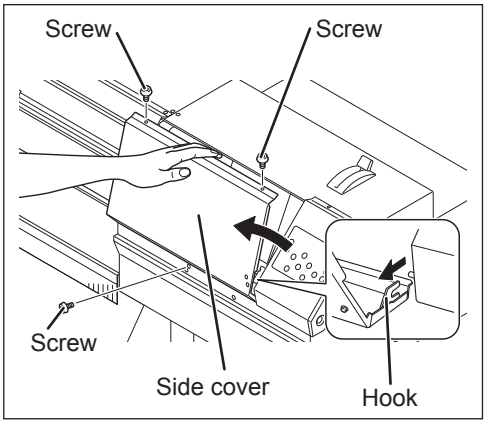
❻

Press ENTER.



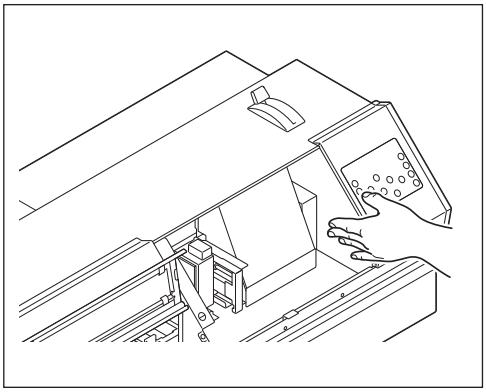
The print-head carriage moves to a location where wiper replacement is possible, and then the screen shown in the figure appears.

❼



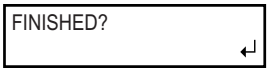
Remove the side cover.

❽



Touch the location shown in the figure to discharge any static electricity.

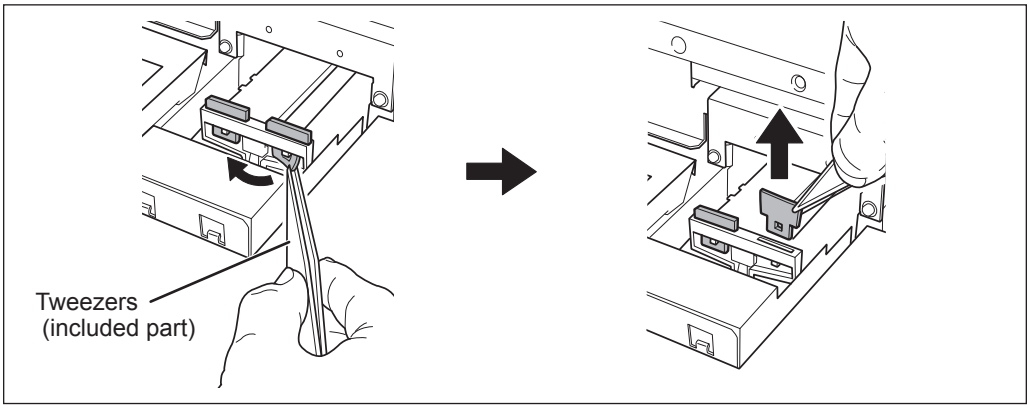
❾

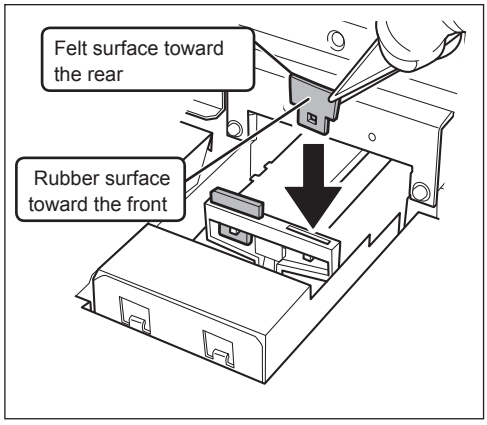


Preparations are complete when this screen appears

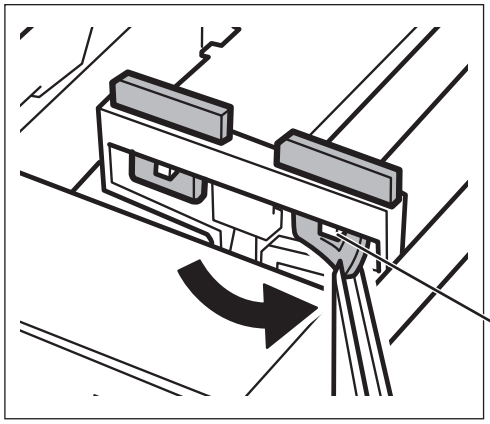
2. Replace the wipers.

❶ **Detach the old wipers.**
Detach the hook and pull up and out.



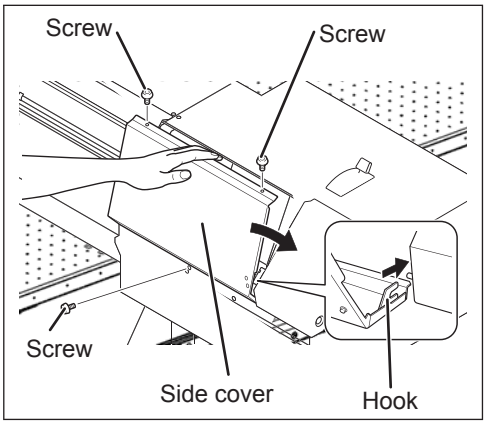
❷ 

Insert the new wipers.

❸ 

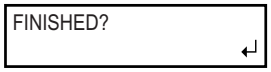
Attach the hook.

3. Quit the wiper replacement menu.

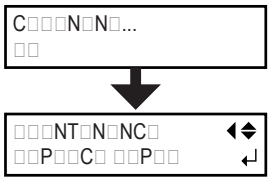
❶ 

Attach the side cover.

❷

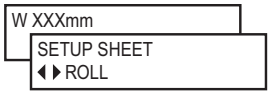


Press ENTER .



After the process to quit the wiper replacement mode, the screen shown in the figure appears.

❸



Press MENU ◄ in this order to go back to the original screen.

4. Perform a printing test to verify the results of the procedure.

Perform a printing test to check the result.

☞ P. 67, "Printing Tests and Normal Cleaning"

When Not in Use for a Prolonged Period

Keep Performing Maintenance

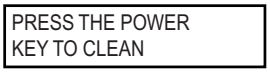
Switch on the power once every two weeks

Switch on the sub power once every two weeks. When you turn on the power, the machine automatically performs some operations such as those to keep the print heads from drying out. Allowing the machine to stand completely unused for a prolonged period may damage the print heads, so be sure to switch on the power to perform these automatic operations.

Keep at a Constant Temperature and Relative Humidity

Even when the machine is not in use, keep it at a temperature of 5 to 40˚C (41 to 104˚F) and a relative humidity of 20 to 80% (with no condensation). If temperatures are too high or too low, it may cause malfunction.

Alarm Feature



This feature is to remind you to switch on the sub power once a month. When the machine remains unused for about one month, this screen appears and a warning beep sounds. If this screen appears, switch on the sub power. When maintenance operations finish, switch off the sub power.
This feature operates when the printer's main power is turned on. We recommend leaving on just the main power to the printer even when the machine is to remain out of use for a prolonged period.

Important Note on Draining Ink

This machine has features for draining internal ink and for performing washing using SOL INK cleaning cartridges, but they should never be used except in special cases. Allowing the machine to stand without ink for a prolonged period may damage the print heads, even if internal washing is performed. Once ink has been filled, then as a rule the ink should never be drained.

Chapter 5
Part of Practice

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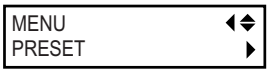
Fully Utilizing Preset Function

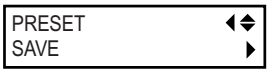
Saving the Various Settings to the Preset

Procedure

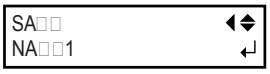
1. **Press MENU.**

2. 

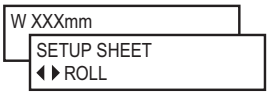
Press ▼ twice to display the left figure.
Press ► and then ▼.

3. 

Press ►.

4. 

Press ▲ ▼ to select one of NAME1 through 8.
Press ENTER to enable the setting.
The present menu settings are saved.

5. 

Press MENU ◄ in this order to go back to the original screen.

Description

Using the [PRESET] menu lets you easily change a wide variety of settings to optimize them for the media. Up to eight types of presets can be saved. You can assign a name to each one. Using media names for these may aid recognition and clarity. Making changes for each menu item every time you change the media can be troublesome. That's why it can be useful to save the menu-item settings optimized for an often-used type of media as a preset. The next time you use the media, you can change the menu-item settings to the optimal values for the media simply by loading the preset you saved. Menu items that can be saved in presets are listed below.

[ADJUST BI-DIR SIMPLE SETTING]	☞ P. 105, "Correcting for Misalignment in Bidirectional Printing"
[ADJUST BI-DIR DETAIL SETTING]	☞ P. 106, "Correcting for Misalignment in Bidirectional Printing More Precisely"
[CALIBRATION]	☞ P. 106, "Alleviating Horizontal Bands and the Like (feed correction function)"
[SHEET TYPE], [SHEET WIDTH], [SHEET POS.]	☞ P. 109, "Using Transparent or High Gloss Media"
[SIDE MARGIN], [FRONT MARGIN]	☞ P. 111, "Expanding the Printing Area by Reducing the Margins"
[VACUUM POWER]	☞ P. 126, "Using the Media Easy to be Winkled / Hard to be Fed"
[FULL WIDTH S]	☞ P. 112, "Speeding Up Output for Narrow Media"

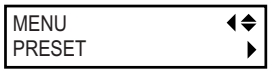
☞ P. 103, "Loading a Saved Preset"

☞ P. 103, "Assigning a Name to a Preset"

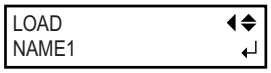
Loading a Saved Preset

Procedure

1. **Press MENU.**

2. 

   Press ▼ to display the left figure.
   Press ► twice.

3. 

   Press ▲ ▼ to select a name to be called.
   Press ENTER to enable the setting.

   The settings are changed and the screen shown in the figure appears.

Description

This loads a saved preset. You can select any one of eight types of presets. (When no names have been assigned, you select from among NAME1 through NAME8.) If you load a preset while SET UP is illuminated, SET UP goes dark. When starting output, press SET UP again to make the output operation available.

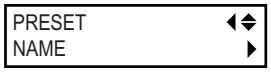
Assigning a Name to a Preset

Procedure

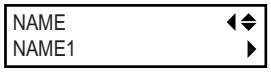
1. **Press MENU.**

2.

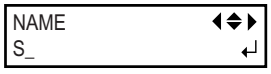
   Press ▼ to display the left figure.
   Press ► and then ▲.

3. 

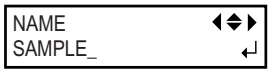
   Press ►.

4. 

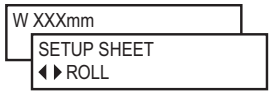
   Press ▲ ▼ to select one of NAME1 through 8.
   Press ►.

5. 

   Press ▲ ▼ to enter a character.
   When a character is decided, press ►.
   The characters you can enter are "A" through "Z," "0" through "9," and the "-" character. You can enter up to 15 characters, including spaces.

6. 

   Press ▲ ▼ to enter a character.
   Enter the following characters in the same way.
   When entries are completed, press ENTER to enable the setting.

7 

Press MENU ◄ in this order to go back to the original screen.

Description

This assigns a name to a saved preset. Using media names may aid recognition and clarity.
The characters you can enter are "A" through "Z," "0" through "9," and the "-" character. You can enter up to 15 characters, including spaces.

Fully Utilizing the Correction Function

Correcting for Misalignment in Bidirectional Printing

Procedure

1. **Press MENU.**

2.

   Press ▼ several times to display the left figure.
   Press ►.

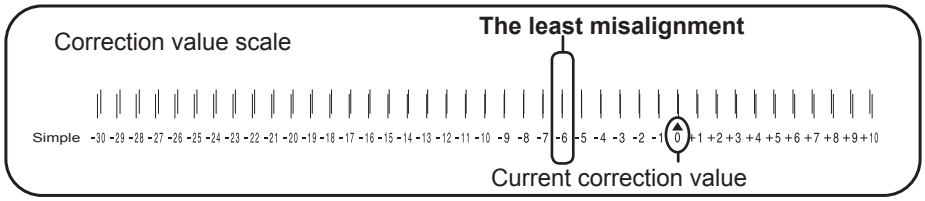
3.

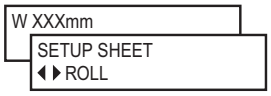
   Press ENTER.
   A test pattern is printed.
   When printing is completed, press ▼ ► in this order.

4.

   Press ▲ ▼ to select a correction value.
   Press ENTER to enable the setting.

To decide a Correction Value
Choose the value that produces the least misalignment of 2lines.


Correction value scale
The least misalignment
Simple -30 -29 -28 -27 -26 -25 -24 -23 -22 -21 -20 -19 -18 -17 -16 -15 -14 -13 -12 -11 -10 -9 -8 -7 -6 -5 -4 -3 -2 -1 0 +1 +2 +3 +4 +5 +6 +7 +8 +9 +10
Current correction value

5. 

   Press MENU ◄ in this order to go back to the original screen.

Description

This machine prints by the bidirectional mode (in which the print heads perform printing during both their outbound pass and return pass). This printing method is called "Bidirectional Printing." This method offers the advantage of being able to shorten output times, but subtle misalignment occurs during the outbound and return passes. The procedure to correct this and eliminate misalignment is "Bidirectional Correction." This misalignment varies according to the print-head height and the thickness of the media, so we recommend performing correction to match the media you're using.

Correcting for Misalignment in Bidirectional Printing More Precisely

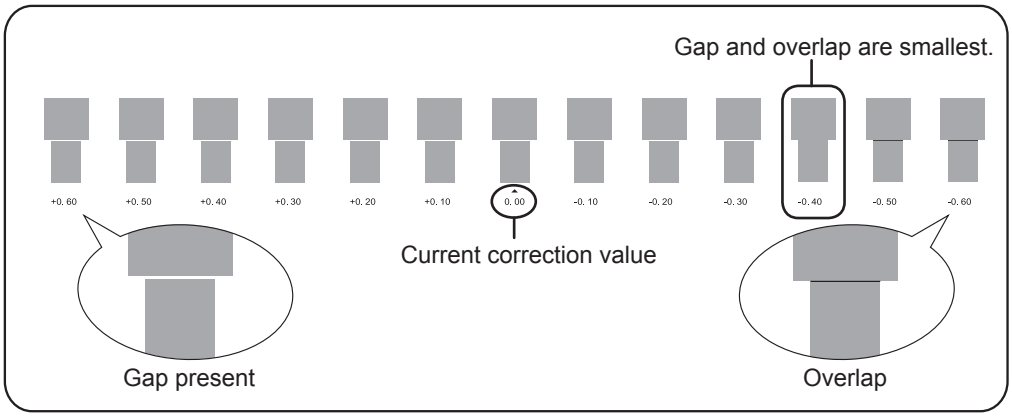
When further correction is required, such as when adjustment made using [SIMPLE SETTING] does not enhance printing, use [DETAIL SETTING] to make corrections.
For information on operations, refer to page 59 "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)".

Alleviating Horizontal Bands and the Like (feed correction function)

Procedure

1. **When the roll media is used, check that no sagging is found on the media.**
2. **Press** (MENU).
3. MENU / CALIBRATION ▶
   Press (▼) **several times to display the left figure.**
   Press (►).
4. CALIBRATION / TEST PRINT ↵
   Press (ENTER).
   A test pattern is printed.
   When printing is completed, press (▼) (►) **in this order.**
5. SETTING / 0.00% ▶ -0.40% ↵
   Press (▲) (▼) **to select a correction value.**
   Press (ENTER) **to enable the setting.**

To decide a correction value
Select the value to make the upper/lower rectangular gap and overlap smallest.



6. W XXXmm / SETUP SHEET ◀▶ ROLL
   Press (MENU) (◄) **in this order to go back to the original screen.**

Description

The movement distance of media experiences subtle changes due to the thickness of the media . When the movement distance becomes discrepant, horizontal stripes are more likely to occur during printing. We recommend performing correction to match the media you're using. Repeat the process of printing a test pattern and entering a correction value several times to find the optimal value.
You can also make this setting on the RIP software computer (by, for example, choosing the media type in the software RIP you are using). When you have made the setting on the software RIP, the software RIP's setting is used and the printer's setting is ignored.

Default Setting

[SETTING]: 0.00%

Accommodating to the Types and Condition of Media

Adjusting the Print-Head Height to Match Media Thickness

Procedure

1. **Press MENU.**

2.

   Press ▼ several times to display the left figure.
   Press ►.

3.

   Press ▲ ▼ to select an item.
   HIGH: Use this setting when using media that may rise up.
   MIDDLE: Use this setting normally (recommended).
   LOW: Use this setting when you want to print small text at high resolution.
   * When "HIGH" or "LOW" is selected, print quality may be affected. See "Description" for more information.
   Press ENTER to enable the setting.

Description

When using media that is likely to rise up, note that the media may contact the print heads. When you are using such media, adjust the print-head height to "HIGH."
When the print-head height is set to "HIGH", printing may be coarse and print quality may be affected. If this happens, refer to the pages indicated below.

- ☞ P. 105, "Correcting for Misalignment in Bidirectional Printing"
- ☞ P. 106, "Correcting for Misalignment in Bidirectional Printing More Precisely"
- ☞ P. 114, "Preventing Soiling of the Media and Dot Drop-out"

Select "LOW" when you want to print small text at high resolution. However, note that because you cannot use the media clamps, the media may rise up and contact the print heads.

Default Setting

[HEAD HEIGHT]: MIDDLE

Using Transparent or High Gloss Media

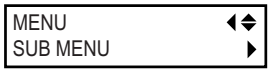
POINT!

Transparent media can be treated as opaque media by affixing an opaque sheet to the reverse side of the media.

When using transparent rigid media such as acrylic media, an opaque sheet, such as a protective sheet, may be affixed to the reverse side of the rigid media. The opaque sheet is not peeled off and the media will be treated as opaque media, therefore the settings described here are not necessary.

1. Set the media type to "CLEAR."

❶ **Press MENU.**

❷ 

Press ▼ several times to display the left figure.
Press ► twice.

❸

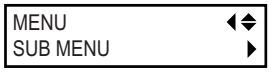
Press ▲ ▼ to select "CLEAR."
Press ENTER to enable the setting.

❹

The settings are changed and the screen shown in the figure appears.

2. Set the media width.

❶ **Press MENU.**

❷ 

Press ▼ several times until the screen shown on the left appears.
Press ►.

❸

Press ▼ several times until the screen shown on the left appears.
Press ►.

❹

Press ▼ ▲ and select a value.

Setting range

- Roll media: 210 to 1625 mm (8.3 to 64 inches)
- Rigid media, Sheet media: 250 to 1625 mm (9.8 to 64 inches)

Press ENTER to enable the setting.

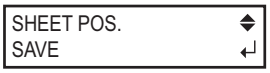
❺

Press ◄ to return to the previous screen.

3. Set the position of the right edge of the media.

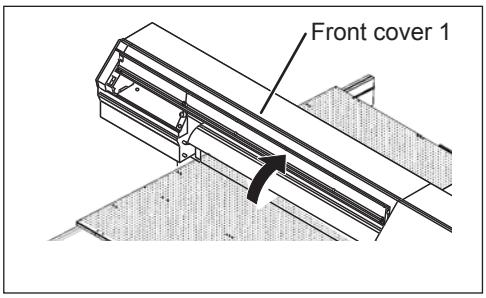
❶ **Press ▼.**

❷



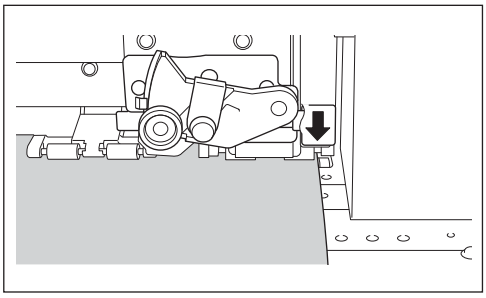
Press ►.
The print heads move to the position now set.

❸



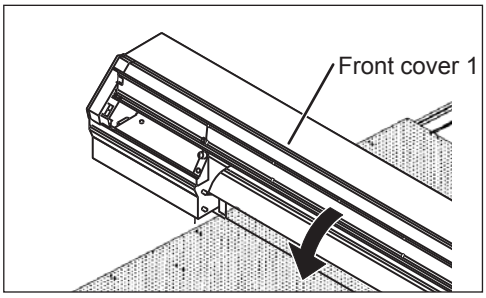
Open the front cover 1.

❹



Press ◄ ► to move the point of the arrow to the right edge of the media, as shown in the figure on the left.

❺



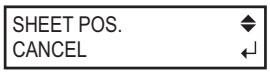
When the position has been set, close the front cover 1.
Press ENTER to enable the setting.

❻

Press MENU ◄ in this order to go back to the original screen.

Description

When using transparent media or opaque, high-gloss media, the width and loading position cannot be read automatically. Therefore they must be set manually. If they are set incorrectly, ink may be applied where there is no media.



To quit making settings at the [SHEET POS.] menu item, use ▼ to select "CANCEL," then close the front cover 1 and press ENTER.
Note that to keep the print heads from drying out, the [SHEET POS.] menu item ends automatically after a certain interval, even if you're still making settings there.
The settings for the media width and start position made here are effective only when [SHEET TYPE] is set to "CLEAR." Selecting "OPAQUE" disables the settings, although the setting values are saved in memory. Choosing "CLEAR" again enables the values set previously.
When using transparent media or opaque, high-gloss media, the machine cannot detect the edge of the media, causing the machine to continue printing even if the media runs out. Therefore when using these types of media, make sure to confirm the size of the print data and the amount of media remaining. To cancel printing, press PAUSE.

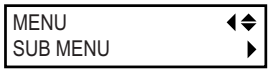
Default Setting

[SHEET TYPE]: OPAQUE
[SHEET WIDTH]: 1625mm (64 inches)

Expanding the Printing Area by Reducing the Margins

Procedure

1. **Press MENU.**

2. 

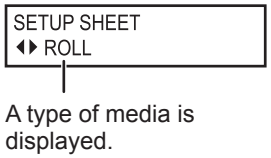
Press ▼ several times until the screen shown on the left appears.
Press ►.

3.

Press ▼ several times until the screen shown on the left appears.
Press ►.

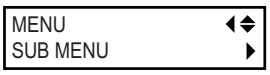
4.

Press ▲ ▼ to select "5 mm (3/16 inch)."
Press ENTER to enable the setting.



When "SHEET SETUP" is set to any value other than "RIGID," the screen shown on the left appears and setting is complete.
When "SHEET SETUP" is set to "RIGID," proceed to the next step.

5 **Press** MENU **.**

6 

Press ▼ several times until the screen shown on the left appears.
Press ► .

7

Press ▼ several times until the screen shown on the left appears.
Press ► .

8

Press ▲ ▼ to select "25 mm (16/16 inch)."
Press ENTER to enable the setting.
Only available when "SETUP SHEET" is set to "RIGID".

Description

The "SIDE MARGIN" setting determines the distance from the left or right media clamp to the corresponding left or right edge of the printing area. You can select "5 mm (3/16 inch)," "10 mm (6/16 inch)," or "25 mm (16/16 inch)." Setting this to "5 mm (3/16 inch)" lets you expand the printing area.
Note, however, that when you're using transparent media, setting this to "5 mm (3/16 inch)" may result in printing on top of the media clamps.
The "FRONT MARGIN" setting determines the distance from the front edge of the rigid media to the printing area. You can select "5 mm (3/16 inch)," "10 mm (6/16 inch)," or "25 mm (16/16 inch)." Setting this to "5 mm (3/16 inch)" lets you expand the printing area.

☞ P. 166, "Printing Area"

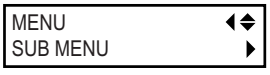
Default Setting

[SIDE MARGIN]: 10mm (6/16 inch)
[FRONT MARGIN]: 10mm (6/16 inch)

Speeding Up Output for Narrow Media

Procedure

1 **Press** MENU **.**

2 

Press ▼ several times to display the left figure.
Press ► .

3

Press ▼ several times to display the left figure.
Press ► .

4

Press ▲ ▼ to select an item.

SHEET

"SHEET" matches the range of print heads movement to the width of the media.

OFF

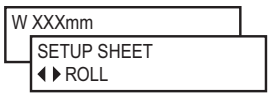
"OFF" matches the range of print heads movement to the output data. Movement is limited to the minimum amount necessary, and this can be expected to yield the fastest output. Note, however, that because the speed of media movement is no longer constant, colors may be uneven.

FULL

This makes the speed of media movement constant at all times and produces the most stable output result.

Press ENTER to enable the setting.

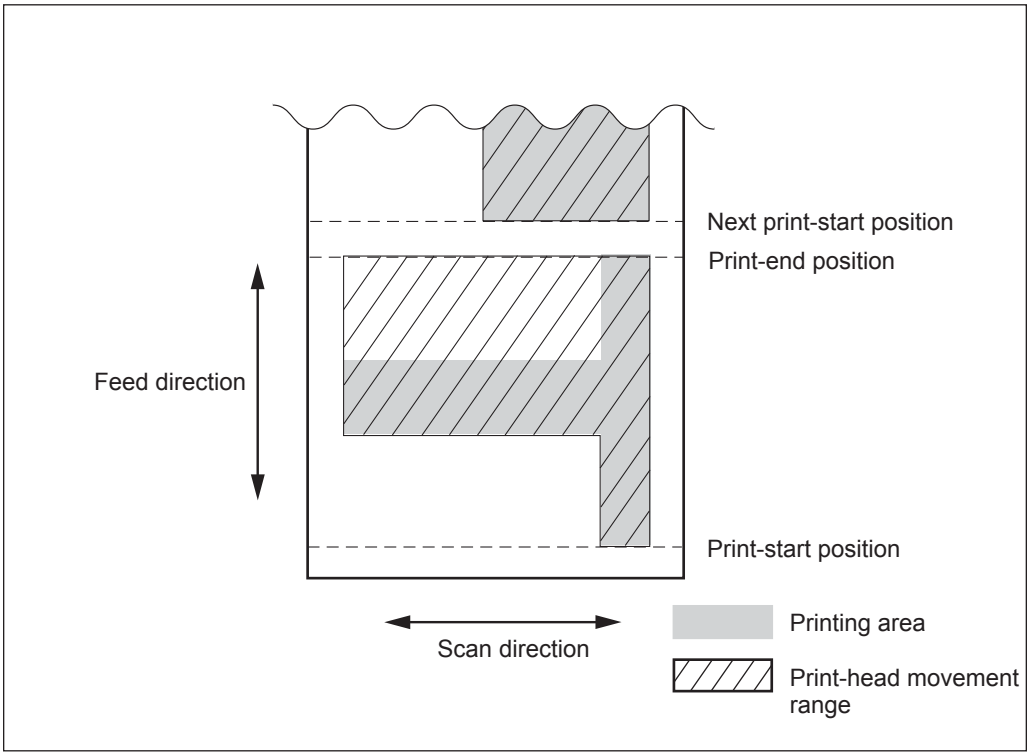
❺



Press MENU ◄ in this order to go back to the original screen.

Description

This shortens print time by reducing the width of print heads movement to the minimum necessary. This is effective when the width of the media or the print data is narrow.



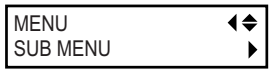
Default Setting

[FULL WIDTH S]: FULL

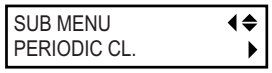
Preventing Soiling of the Media and Dot Drop-out

Procedure

1. **Press MENU.**

2. 

Press ▼ several times to display the left figure.
Press ►.

3. 

Press ▼ several times to display the left figure.
Press ►.

4.

Press ▲ ▼ to select an item.

PAGE

Automatic cleaning is performed every time before printing starts.

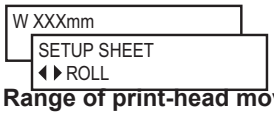
5 to 990 min

Automatic cleaning is performed when the cumulative printing time reaches the value you set here.

NONE

Automatic cleaning is not performed.

Press ENTER to enable the setting.

5. 

Press MENU ◄ in this order to go back to the original screen.

Range of print-head movement when set to "OFF"

Description

In the following cases, Ink tends to collect on the surface of the print heads. Under some conditions, this ink may be transferred to the media or cause dot drop-out.

- When you use media prone to buildup of static charge.
- When the ambient temperature is low.
- When the print-head height is set to "HIGH."

Selecting "PAGE" or a value from "5 min" to "990 min," the ink buildup is removed before or during printing while printing is performed. Note, however, that using "PAGE" or a value from "5 min" to "990 min," results in longer printing times.

Default Setting

[PERIODIC CL.]: NONE

Printing with Crop Marks

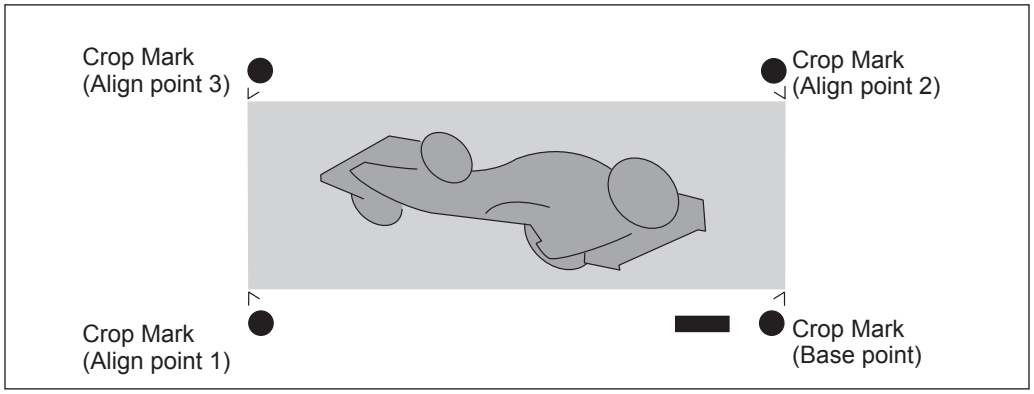
Printing with Crop Marks

Use your software RIP to make the settings for printing crop marks. For information on how to make the setting, refer to the documentation for the software RIP you're using.

IMPORTANT!

Alignment marks and symbols drawn using a graphics program cannot be used as crop marks.

The crop marks are printed as shown in the figure.



Switching the Ink Type

Restrictions on Switching Ink Type

On this machine, you can switch the ink type using the [HEAD WASH] menu after filling with ink.

However, there are the restrictions given below:

- **The ink types that can be used on this machine are the ECO-UV ink and ECO-UVS ink.**
- **When you select [ECO-UV CMYKGIGI] (*1) or [ECO-UV CMYKGIW] (*2) when you fill with ink for the first time, you cannot switch the ink type from the ECO-UVS ink to ECO-UV ink.**
- **You can only select [ECO-UV CMYKWW] (*3) when you switch the ECO-UVS ink to ECO-UV ink.**

ECO-UV CMYKGIGI ⇨ ECO-UVS CMYKWW (*4)	OK
ECO-UV CMYKWW ⇨ ECO-UVS CMYKWW	OK
ECO-UV CMYKGIW ⇨ ECO-UVS CMYKWW	OK
ECO-UVS CMYKWW ⇨ ECO-UV CMYKGIGI	Not OK
ECO-UVS CMYKWW ⇨ ECO-UV CMYKWW	OK (*5)
ECO-UVS CMYKWW ⇨ ECO-UV CMYKGIW	Not OK

(*1) Cyan, magenta, yellow, and black ECO-UV ink cartridges and two gloss ink cartridges are used.

(*2) Cyan, magenta, yellow, and black ECO-UV ink cartridges, one gloss ink cartridge, and one white ink cartridge are used.

(*3)Cyan, magenta, yellow, and black ECO-UV ink cartridges and two white ink cartridges are used.

(*4) Cyan, magenta, yellow, and black ECO-UVS ink cartridges and two white ink cartridges are used.

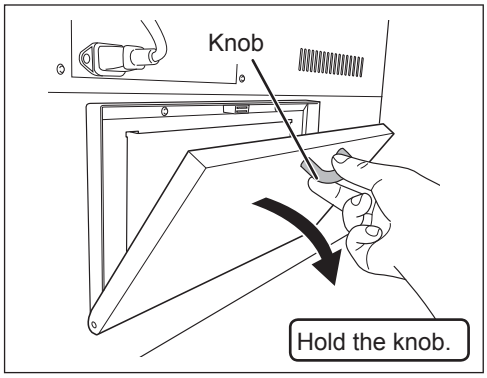
(*5) When you select [ECO-UV CMYKGIGI] or [ECO-UV CMYKGIW] when you fill with ink for the first time, you cannot switch the ink type from the ECO-UVS ink to ECO-UV ink.

Method for Switching the Ink Type

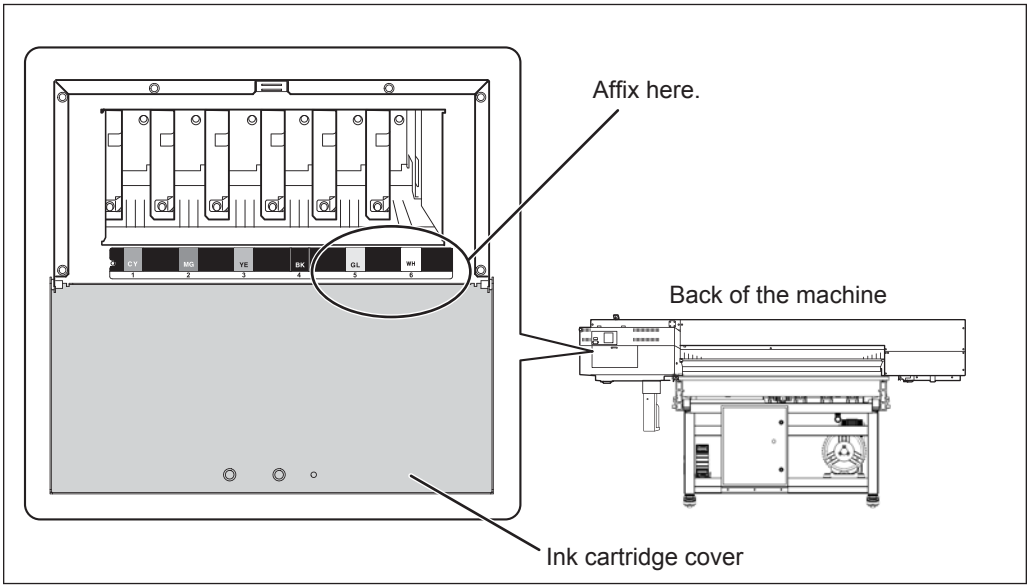
This operation requires four unused SOL INK cleaning cartridges. Have these on hand before you start.

1. Affixing the cartridge-slot labels.

❶ **Open the ink cartridge cover.**



❷ **If WH [ ] WH is not affixed, affix it to the location shown in the figure.**



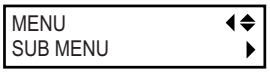
After affixing	CY 1 · MG 2 · YE 3 · BK 4 · WH 5 · WH 6

2. Drain the ink and wash the interior.

IMPORTANT!

Insert each color ink cartridge into the slot labeled with the matching color. If you insert wrong cartridges when filling ink, the condition cannot be restored easily. Contact your authorized Roland DG Corp. dealer or us., if you filled ink with wrong cartridges inserted.

1. **Press** (MENU).

2. 

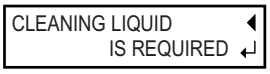
Press (▼) several times until the screen shown on the left appears.
Press (►).

3.

Press (▲) several times until the screen shown on the left appears.
Press (►) (▲) in this order.

4.

Press (ENTER).

5. 

Make sure the cleaning liquid is ready.
Press (ENTER).

6.

Discard the discharged ink in the drain bottle.
Be sure to discard the discharged ink.
Press (ENTER).

7. **Thereafter, follow the on-screen instructions to carry out the operations.**
After cleaning has finished, the sub power is automatically switched off.

⚠WARNING **Never put discharged fluid or ink closed to fire.**
Doing so may cause the blaze.

⚠CAUTION **To store discharged fluid temporarily, keep it in the provided drain bottle or in a durable container such as a metal can or polyethylene tank, and close the cap tightly.**
Any spillage or vapor leakage may cause fire, odor, physical distress.

Store discharged fluid in a location not exposed to direct sunlight.

When temporarily storing discharged fluid in the included drain bottle, keep the drain bottle out of direct sunlight. Otherwise the discharged fluid may harden, making the drain bottle unusable.

Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.

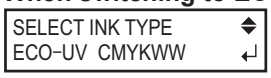
Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing so may have an adverse impact on the environment.

3. Fill with ink.

1 Press the sub power button.

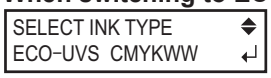
2 Select the ink type.

<When switching to ECO-UV ink>



Press ▲ ▼ to display the left figure.
Press ENTER.

<When switching to ECO-UVS ink>



Press ▲ ▼ to display the left figure.
Press ENTER.

3 Thereafter, follow the on-screen instructions to carry out the operations.
After finishing the operation, close the ink cartridge cover.

IMPORTANT!

When you use VersaWorks

Be sure to perform the following operation after filling with ink. Otherwise, you cannot use VersaWorks.

Procedure

1 From the [Start] menu, click [All programs (or Programs)] - [Roland VersaWorks] - [Roland VersaWorks] - [Initialize Application].

2 Click [Yes] when a confirmation message for initialization of the application appears.

3 Click [OK] when a completion message for initialization of the application appears

4 Start VersaWorks.
The [Printer Settings] window is displayed. This is because the connection with the printer is initialized by performing Initialize Application.

5 Make the settings of the printer.
☞ "Printer Connection and Settings" in "Roland VersaWorks Quick Start Guide"
When you initialize the application, the settings of Roland@NET are initialized as well. Please make the settings again.
☞ "Making the Settings for Roland@NET" in "Roland VersaWorks Quick Start Guide"

Chapter 6
To Administrators

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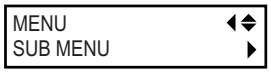
Output Operation Management

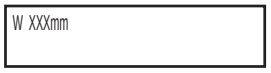
Printing a System Report

This prints system information, including a list of setting values.

Procedure

1. **Press MENU.**
2. 

Press ▼ several times to display the left figure.
Press ► .
3.

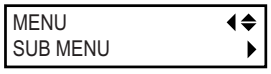
Press ▼ several times to display the left figure.
Press ENTER .
Start printing.
4. 

Press MENU ◄ in this order to go back to the original screen.

Determining What Happens When Ink Runs Out

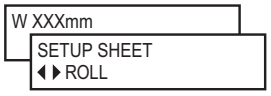
This lets you change, according to your purpose, the operation that takes place when an ink cartridge is empty.

Procedure

1. **Press MENU.**
2. 

Press ▼ several times to display the left figure.
Press ► .
3.

Press ▲ several times to display the left figure.
Press ► twice.
4.

Press ▲ ▼ to select.
"STOP": Printing pauses immediately when a cartridge becomes empty.
"CONT" (continue): Printing does not stop when a cartridge becomes empty. When a cartridge becomes empty, a warning beep sounds.
Press ENTER to enable the setting.
5. 

Press MENU ◄ in this order to go back to the original screen.

Description

When "STOP" is selected, printing pauses and so colors may be uneven. Ensure a sufficient amount of remaining ink before you begin printing.
When "CONT" is selected, printing does not stop even if ink runs out completely. To replace the cartridge, wait until printing ends or press (PAUSE) to pause printing.

Default Setting

[EMPTY MODE]: STOP

Displaying the Amount of Media Remaining

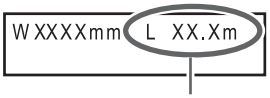
You can display how much of the media in use is left. First, you set the amount of media remaining, the amount remaining is displayed at the top menu until it reaches zero.

Procedure

1. **Press (MENU).**
2.

Press (▲) several times to display the left figure.
Press (►) and then (▼).
3.

Press (►).
4.

Press (▲) (▼) to set the current amount of media remaining.
Press (ENTER) to enable the setting.
5. 

Press (MENU) (◄) in this order to go back to the original screen.

This display is updated.

If setup has not been performed, the set value flashes.

Description

If you cancel the setup such as by removing the media or raising the loading lever, the amount remaining at that time flashes on the screen.
Because the amount of media remaining is not updated automatically when you change the media, redo the setting whenever you change the media. You can also make the setting display this menu automatically whenever you change the media. See the next section, "Making Sure to Verify the Setting for the Amount Remaining Every Time the Media Is Changed"
Note: The remaining amount that is displayed is only an estimate, and its accuracy is not assured.

Making Sure to Verify the Setting for the Amount Remaining Every Time the Media Is Changed

Set to display

every time when a media is changed.

Procedure

1. **Press MENU.**

2.

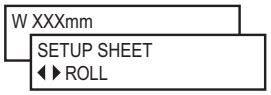
   Press ▲ several times to display the left figure.
   Press ► and then ▲.

3.

   Press ►.

4.

   Press ▲ ▼ to select "ENABLE".
   Press ENTER to enable the setting.
   If you set to "ENABLE," you must set the [SHEET TYPE] menu to "OPAQUE"
   ☞ P. 123, "Using Transparent or High Gloss Media"

5. 

   Press MENU ◄ in this order to go back to the original screen.

Description

Setting this menu to "ENABLE" can keep you from forgetting to redo the setting when you change the media. Be sure, however, also to set the [SHEET TYPE] menu (refer to P. 123, "Using Transparent or High Gloss Media") to "OPAQUE." When [SHEET TYPE] is set to "CLEAR," [SHEET REMAIN] is not displayed automatically.

Default Setting

[AUTO DISPLAY]: DISABLE

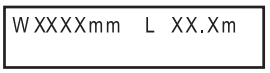
Printing the Amount of Remaining Media

This prints the amount of media remaining that is displayed at the top menu.

Procedure

1. **Press MENU.**
2.

Press ▲ several times to display the left figure.
Press ►.
3.

Press ENTER.
Start printing.
4. 

Press MENU ◄ in this order to go back to the original screen.

Description

You use this when you want to make a record of the remaining length of the media now in use. Printing the amount of media remaining before you change the media enables you to refer to the printed record and use the value to make the setting for the remaining amount the next time you use the media.
Note, however, that continuing by performing the next output starts the output on top of the portion where the amount of remaining media is printed. After printing the amount remaining, then before you perform the next output operation, we recommend cutting off the media.

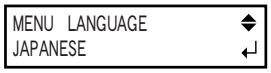
System Management of Printer

Setting for the Menu Language and the Units of Measurement

This sets the language and units of measurement displayed on the display screen of the operation panel.

Procedure

1. **Hold down (MENU) and switch on the sub power.**

2. 

Use (▲) (▼) to select the display (menu) language.
Press (ENTER) to enable the setting.

3.

Use (▲) (▼) to select the measurement unit for length.
Press (ENTER) to enable the setting.

4.

Use (▲) (▼) to select to the measurement unit for temperature.
Press (ENTER) to enable the setting.

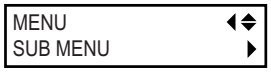
Default Setting

[MENU LANGUAGE]: ENGLISH
[LENGTH UNIT]: mm
[TEMP. UNIT]: °C

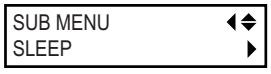
Setting the Interval until Activation of the Sleep Mode (Power Saving Function).

Procedure

1. **Press (MENU).**

2. 

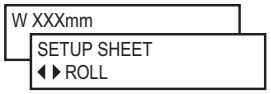
Press (▼) several times to display the left figure.
Press (►).

3. 

Press (▲) several times to display the left figure.
Press (►) twice.

4.

Use (▲) (▼) to make the setting.
Press (ENTER) to enable the setting.

5. 

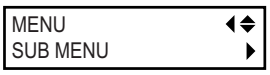
Press (MENU) (◄) in this order to go back to the original screen.

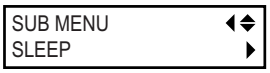
Default Setting

[INTERVAL]: 30min

Deactivating the Sleep Mode (Power Saving Function)

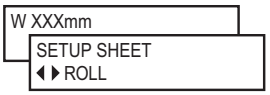
Procedure

1. Press (MENU).
2. 

Press (▼) several times to display the left figure.
Press (►).
3. 

Press (▼) several times to display the left figure.
Press (►) and then (▼).
4.

Press (►)
5.

(▲) (▼) to select "DISABLE."
Press (ENTER) to enable the setting.
6. 

Press (MENU) (◄) in this order to go back to the original screen.

Default Setting

[SETTING]: ENABLE

Viewing Information about the System of the Printer

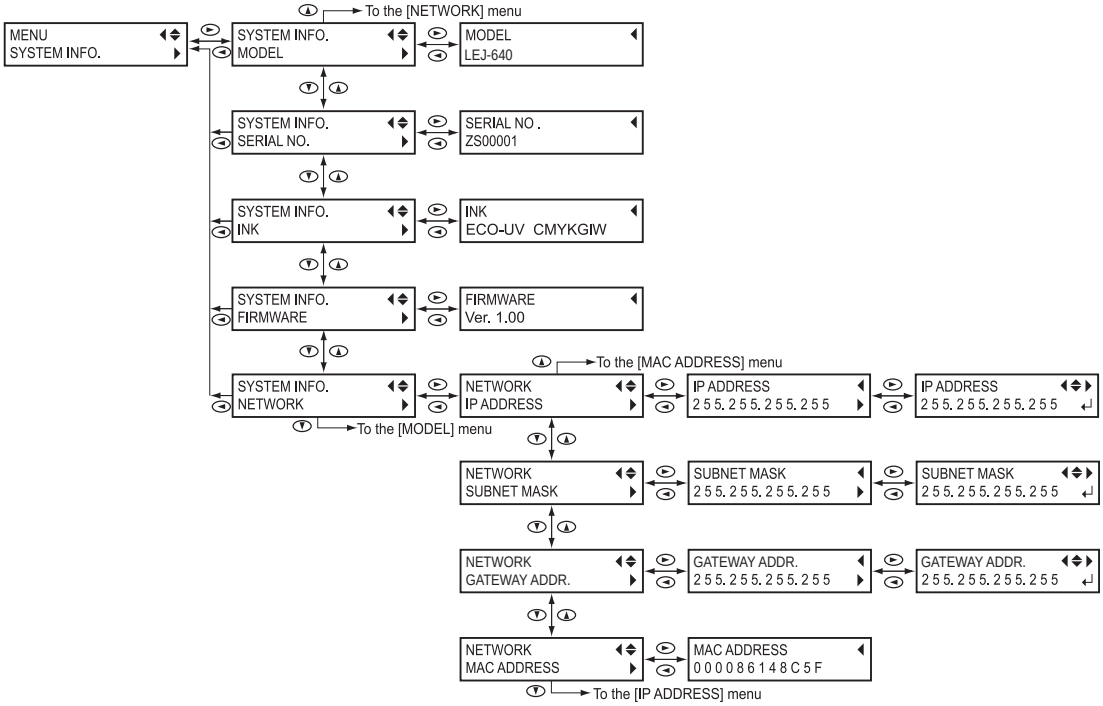
Note: For information on how to set up a network, refer to "Setup Guide."

Procedure

1. **Press** (MENU) **.**

2. MENU
   SYSTEM INFO. ▶

   Press (▲) several times to display the left figure.
   You can view the following information.
   [MODEL]: Model name
   [SERIAL NO.]: Serial number
   [INK]: Ink type
   [FIRMWARE]: Firmware version
   [NETWORK]: Network configuration (IP address, etc)



Returning All Settings to Their Initial Values

Viewing Information about the Keypad

Note: For information on how to set up a network, refer to "Setup Guide."

Procedure

1. **Press** 3 INFO.

2.

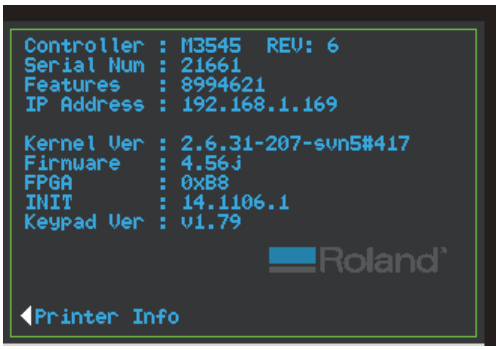
Press INFO to display the left figure.
You can view the following information.

[MODEL]: Model name
[SERIAL NO.]: Serial number
[Command Set] Command Set for Keypad
[FIRMWARE]: Firmware version
[State]: Printer Status
Ink Levels

Press Right Arrow to display the page #2 (below figure).

[Controller]
[Controller Serial Number]
[Features]
[IP Address]: Network configuration (IP address, etc)

[Kernel Ver]:
[Firmware]:
[FFGA]:
[INIT]:
[Keypad Vers]:

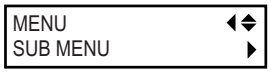


Returning All Settings to Their Initial Values

This menu returns all settings to the same as their factory defaults. However, the settings for [MENU LANGUAGE], [LENGTH UNIT], and [TEMP. UNIT] are not returned to the factory defaults.

Procedure

1. **Press** (MENU) **.**

2. 

   Press (▼) **several times to display the left figure.**
   Press (►) **.**

3.

   Press (▼) **several times to display the left figure.**
   Press (ENTER) **to execute.**

Chapter 7
Read this chapter whenever you face a problem. (FAQ)

The Machine Doesn’t Run 131
The Printer Unit Doesn't Run 131
Attractive Printing is Impossible 132
Printed Results Are Coarse or Contain Horizontal Stripes 132
Colors Are Unstable or Uneven 133
The Media Becomes Soiled or Damaged When Printed 135
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A Message Appears 140
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The Machine Doesn’t Run

The Printer Unit Doesn't Run

Is the power switched on?

Switch on the printer's main power, then press the sub power switch and make sure the sub power switch lights up.

☞ P.45, "Switch On"

Is (SET UP) illuminated?

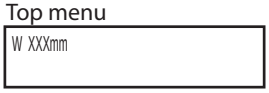
Output is not performed when (SET UP) is not illuminated. Pull back the loading lever, close the front cover 1, and press (SET UP).

Is the cover open?

Close front cover 1, front cover 2, side cover, and maintenance cover.

Is the top menu displayed?

Top menu



If the top menu isn't displayed, output doesn't start even when data is sent from the computer. To go to the top menu, press (MENU), then press (◄).

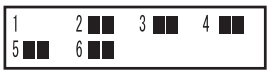
☞ P.64, "Getting Ready to Receive Data from a Computer"

Is (PAUSE) illuminated?

When (PAUSE) lights up, operation is paused. To resume, press (PAUSE). (PAUSE) goes dark and outputting resumes.

☞ P.66, "Pausing and Canceling Output"

Has ink run out?



When printing data is sent while the screen shown in the figure is displayed, a message appears and a warning beep sounds. At the same time, operation pauses. When the ink cartridge is replaced with a new one, output or cutting starts.

☞ P.78, "How to Replace Ink Cartridges"
☞ P.126, "Determining What Happens When Ink Runs Out"

Is a message displayed on the screen?

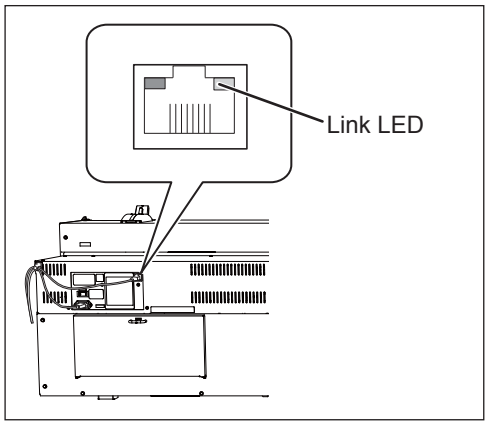
☞ P. 141, "A Message Appears"
☞ P. 143, "An Error Message Appears"

Is the cable connected?

Connect the cable securely.

☞ "Setup Guide"

Is the Link LED lighted?



If the Link LED for the Ethernet connector is not lighted, it means that a correct connection to the network has not been made. Make sure the network routing is suitable. Try connecting the computer and the machine to the same hub, or connecting them directly using a crossover cable. If this makes it possible to perform output, it means the problem is in the network itself.

Are the network settings correct?

If output is impossible even though the link LED is on, make sure the IP address and other settings are correct. The settings on both the machine and the computer must be appropriate. Redo the settings, checking to ensure that the IP address doesn't conflict with the IP address for another device on the network, that the port setting for the software RIP specifies the IP address set on the machine, that the settings have no typing errors, and for other such problems.

☞ "Setup Guide,"

☞ P. 132, "Viewing Information about the System of This Machine"

Did the software RIP end abnormally?

Make sure the software RIP is running correctly, then switch the sub power switch off and back on.

☞ "Roland VersaWorks Quick Start Guide"

Is the temperature of the room too low?

Use the machine in an environment where the temperature is 20 to 32°C (68 to 90°F).

Attractive Printing is Impossible

Printed Results Are Coarse or Contain Horizontal Stripes

Do the print heads show dot drop-out?

Carry out a printing test and make sure no dot drop-out occurs. If dot drop-out is present, perform cleaning of the print heads.

☞ P. 62, "Printing Tests and Normal Cleaning"
☞ P. 86 "When Normal Cleaning Is Not Effective"
☞ P. 96, "The Concentration and Dot Drop-Out of the White Ink"

Is the print-head height appropriate?

When [HEAD HEIGHT] is set to [HIGH], the print is rougher than when it is set to [MIDDLE] or [LOW]. Normally set to "MIDDLE", except when using media that is likely to rise up. (When it is set to [LOW], the ability for the media to pass through the machine may be affected because the media clamps cannot be used.)

☞ P. 112, "Adjusting the Print-Head Height to Match Media Thickness"

Have you carried out feed correction?

Large misalignment in the amount of feed of the media may result in printing that seems coarse or contains horizontal stripes. Either make the setting on the software RIP to match the type of media you're using, or make the setting for correction on the printer.

☞ P. 111, "Alleviating Horizontal Bands and the Like (feed correction function)"

Have you carried out bidirectional correction?

When you are performing bidirectional printing, use the [ADJUST BI-DIR] menu item to carry out correction. The optimal adjustment value may vary, depending mainly on the thickness of the media. Set or select an adjustment value that is suited to the media. When further correction is required, such as when adjustment made using [SIMPLE SETTING] does not enhance printing, use [DETAIL SETTING] to make correction.

☞ P. 110, "Correcting for Misalignment in Bidirectional Printing"
☞ P. 111, "Correcting for Misalignment in Bidirectional Printing More Precisely"

Is the print mode suitable?

Try a higher-quality print mode. Depending on the media, uneven colors may occur in high-quality print modes, and the results are also greatly affected by the settings of the software RIP (such as the selected color profile). Make settings suited to the media you're using.

Is the printer installed in a level and stable location?

Never install the machine in a location where it is tilted or where it may wobble or experience vibration. Also make sure that the print heads are not exposed to moving air. These factors may lead to missing dots or reduced printing quality.

Is the printer installed in a location out of direct sunlight?

Never install in a location exposed to direct sunlight. Doing so may result in dot drop-out or other problems with reduced printing quality, or may even result in malfunction.

Is the media loaded and set up correctly?

If the media is not loaded and set up correctly, media feed may not be smooth, or printing may be adversely affected. Make sure the media is loaded and set up correctly.

☞ P. 49, "Loading Media"

Is the print side of the rigid media warped with wrinkles or waves more than 0.5 mm (0.02 inches) high?

Use Roland VersaWorks to set unidirectional printing. If the problem is still not resolved, the wrinkles or waves are too large. Use media with no wrinkles or waves in it.

☞ P. 54, "Configuring Uni- and Bi-directional Printing (Roland VersaWorks)"

Are the settings for the [PRESET] menu item appropriate?

If the settings selected with the [PRESET] menu item are not suitable for the type of media, printing may be adversely affected. Choose settings optimized to the media you're using.

☞ P.58, "Setup of Media"
☞ P. 110, "Fully Utilizing Preset Function"

Colors Are Unstable or Uneven

Did you shake the ink cartridges gently before installing them?

Shake new cartridges gently before you install them.

Did you shake the white ink cartridges gently before installing them?

The ingredients in white ink tend to settle. Prolonged use of this machine may cause the concentration of the white ink to decrease.

☞ P. 82, "Maintenance of Ink Cartridges"
☞ P. 96, "The Concentration and Dot Drop-Out of the White Ink"

Was printing paused partway through?

When printing is paused, the coloring at the seam may be altered when printing resumes. Avoid pausing printing. By default, printing pauses when ink remaining inside the machine runs out. Before you perform lengthy printing, check the amount of ink remaining in the ink cartridges. Printing may also pause when data is not sent from the computer quickly enough. We recommend not performing any other tasks with the computer while printing is in progress.

Is the printer installed in a level and stable location?

Never install the machine in a location where it is tilted or where it may wobble or experience vibration. Also make sure that the print heads are not exposed to moving air. These factors may lead to missing dots or reduced printing quality.

Are the operating parameters set to appropriate values?

Depending on the settings for such menu items as [FULL WIDTH S] and [PERIODIC CL.], uneven colors may occur. If the settings have been changed, try restoring them to their default values.

☞ P. 117, "Speeding Up Output for Narrow Media"
☞ P. 119, "Preventing Soiling of the Media and Dot Drop-out"

Is the printer being used in a location subject to severe changes in the operating environment?

Large fluctuations in temperature or humidity while printing is in progress may cause the colors to change partway through. When you're performing printing, use the machine in a location where temperature and humidity are stable.

Is the relative humidity of the environment 35% or less? Is static electricity likely to form in the environment?

Keep the machine's environment between 35% and 80% when operating the machine. Static electricity is more likely to form at lower temperatures, and the pinch rollers may become charged with static electricity, causing inconsistent colors. If the temperature of the environment is not the problem, use a device to remove the static electricity charge from the pinch rollers. If there is a high degree of static electricity, keep the operating environment at a relative humidity of 50% or higher.

Are the settings for the [PRESET] menu item appropriate?

If the settings selected with the [PRESET] menu item are not suitable for the type of media, printing may be adversely affected. Choose settings optimized to the media you're using.

☞ P. 107, "Fully Utilizing Preset Function"

The Media Becomes Soiled or Damaged When Printed

Do the print heads contact the media?

The print-head height may be too low. Also, if the media is not loaded and set up correctly, it may wrinkle or come loose and strike the print heads.

☞ P. 112, "Adjusting the Print-Head Height to Match Media Thickness"

Are the print heads dirty?

The following may cause ink to drip on the media during printing.

- Buildup of fibrous dust (lint) around the print heads.
- Ink transferred to the print heads due to rubbing against the media.

If this happens, perform the manual cleaning. We recommend carrying out periodic cleaning of the print heads.

☞ P. 82, "Maintenance that Should Be Performed More Than Once a Month"

- Too Low Humidity.

Use this machine in the environment of 35 to 80 %RH (non condensation).

Are the pinch rollers, media clamps, grit rollers, or the rubber covers on the front of the machine or on the front cover 2 dirty?

Periodically clean them.

☞ P. 84, "Cleaning"

Are the pinch rollers positioned correctly on top of the rigid media?

Adjust the position of the media so that the pinch rollers are completely on top of the media. If the pinch rollers are not completely on top of the media, the media will still pass through the machine, however, depending on the characteristics of the media, an imprint from the pinch rollers may be left behind or the media may be dented.

☞ P. 49, "Loading Media"

Media Jam Occurs

The Media Jams

If an error message is displayed because the media has jammed, immediately correct the problem. Failure to do so may damage the print heads.

- P. 145, "[MOTOR ERROR TURN POWER OFF]"
- P. 145, Press the Emergency Stop button and remove damaged media.

Is the print-head height too low?

Try raising the print-head height. Media may inevitably warp or wrinkle slightly, so adjust the print-head height to take this into account.

- P. 112, "Adjusting the Print-Head Height to Match Media Thickness"

Is the temperature of room too low?

Use this machine in an environment having an ambient temperature of 20 to 32°C (68 to 90°F). If used in the environment where the temperature is below 20°C, the media may get wrinkled depending its type or width.

Is the using media deflected?

If using the deflected media, it cause winkle of the media.

Is the humidity of the room too high?

Use this machine in the environment of 35 to 80 %RH (non condensation).

Is the media severely warped?

Media cannot be fed smoothly when it is warped. Do not use severely warped media.

☞ P. 43, "Usable Media"

The Print Heads Stopped Moving

If the print-head carriage stops over the platen, take action immediately to prevent the print heads from drying out.

What to Do First

Press

(Shift / Return to Origin). The printer will raise up and move to the 0/0 position.

Note: If the printer still does not respond, switch the sub power off, then back on again.

If the media is jammed, then also remove the media.

If the print-head carriage moves to the standby position (the right side of the main unit), it means the operation has ended successfully.

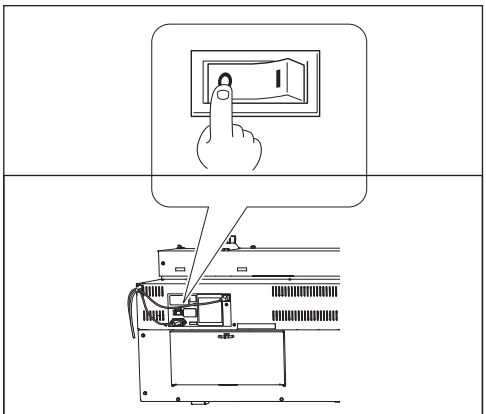
If the print heads still do not move

Try switching off the main power, then again switching on the main power, followed by the sub power.

If the Print Heads Still Do Not Move

If the print heads still do not move, carry out the following emergency response measure, then contact your authorized Roland DG Corp. dealer.

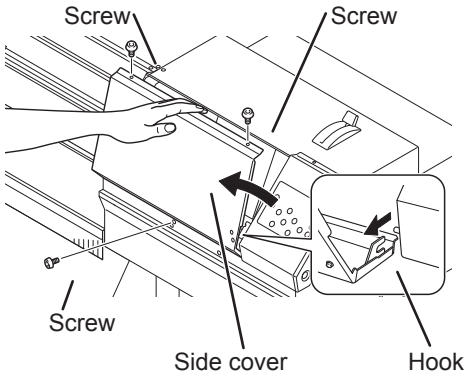
Procedure

❶ 

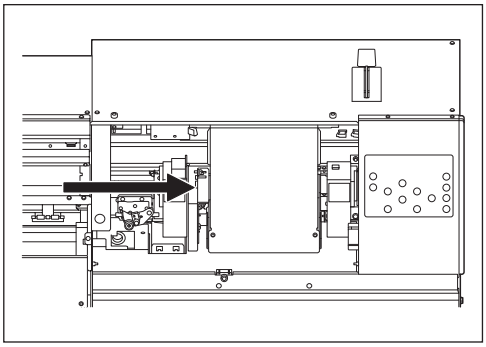
Switch off the main power.

❷ **Open the front cover 1.**

❸ **Detach the side cover.**

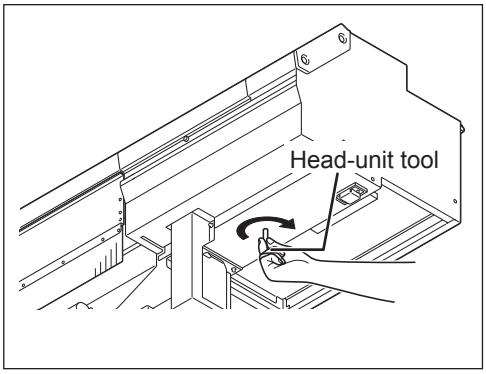


4



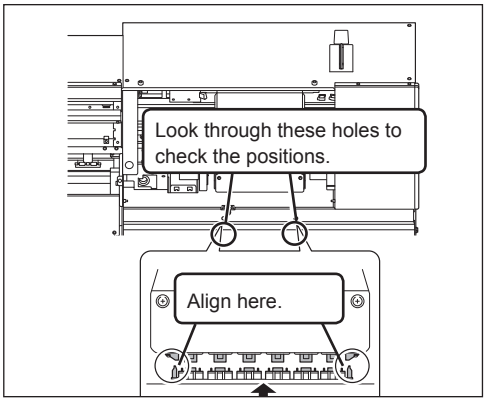
Gently move the print heads by hand as far as the standby position.

5



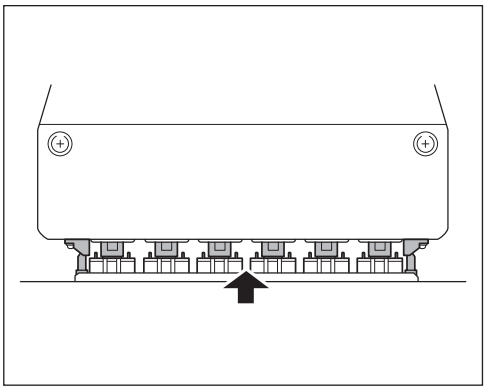
Insert the head-unit tool into the hole at the bottom of the machine and turn gently.
The cap unit rises.

6



Make the guides at the edges of the print heads line up with the guides at the edges of the cap unit.

7



Turn the head-unit tool until the print heads make contact with the cap unit.

8 **When the print heads make contact with the cap unit, turn the head-unit tool one or two turns more.**

Make sure the print heads are capped tightly.

If the cap unit does not reach the print heads, contact your authorized Roland DG Corp. dealer.

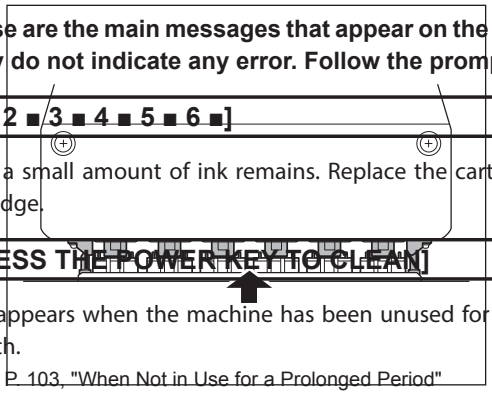
A Message Appears

These are the main messages that appear on the machine's display to prompt correct operation. They do not indicate any error. Follow the prompts and take action accordingly.

[1 ■ 2 ■ 3 ■ 4 ■ 5 ■ 6 ■]

Only a small amount of ink remains. Replace the cartridge indicated by the flashing number with a new cartridge.

[PRESS THE POWER KEY TO CLEAN]



This appears when the machine has been unused for about one month. Switch on the sub power once a month.

☞ P. 103, "When Not in Use for a Prolonged Period"

[CIRCULATING INK]

The white ink is being circulated inside the machine. This is automatically performed to clear the precipitation of the white ink. Wait until the displayed message changes.

[SET CARTRIDGE]

Insert the ink cartridge indicated by the flashing number. This message appears at times such as during ink cartridge replacement.

[REMOVE CARTRIDGE]

Remove the ink cartridge indicated by the flashing number. This message appears at times such as during ink cartridge replacement.

[CLOSE THE COVER (FRONT COVER, SIDE COVER or MAINTENANCE COVER]

Close the front cover 1, front cover 2, side cover, maintenance cover. For safety, the print-head carriage does not operate while a cover is open.

[SET CL-LIQUID]

Insert the SOL INK cleaning cartridge indicated by the flashing number. This message appears at times such as during cleaning of the print heads.

[REMOVE CL-LIQUID]

Remove the SOL INK cleaning cartridge indicated by the flashing number. This message appears at times such as during cleaning of the print heads.

[END OF THE SHEET]

The trailing edge of the media was detected during operation. Press any button on the operation panel to clear the message. Load new media.

[SHEET NOT LOADED PRESS SETUP KEY]

Load media and press (SET UP). This message appears when an attempt to perform a printing test was made while no media was loaded.

[INSTALL DRAIN BOTTLE]

Check whether the drain bottle is installed. Install the drain bottle, then press ENTER .

[CHECK DRAIN BOTTLE]

This appears when a certain amount of discharged fluid collects in the drain bottle. To clear the message, press ENTER . If this screen appears, go to the [DRAIN BOTTLE] menu and discard the discharged fluid in the bottle.

☞ P. 83, "Disposing of Discharged Ink"

[CAN'T SETUP]

This is displayed when the print heads may have contacted the media and media setup is interrupted. Adjust the print-head height and set up the media again.

☞ P. 60, "Enter the thickness of the rigid media."
☞ P. 112, "Adjusting the Print-Head Height to Match Media Thickness"

[REMOVE MEDIA CLAMPS]

This appears when media cutoff is attempted without first removing the media clamps. The media cutoff starts when ENTER is pressed after the media clamps are removed. Pressing ◄ while this message is displayed quits cutoff.

[TIME FOR MAINTENANCE]

The time has come to perform the manual cleaning. After verifying, press ENTER .

☞ P. 89, "Performing Manual Cleaning"

[TIME FOR WIPER REPLACE]

It is time to replace the wipers. After verifying, press ENTER .

☞ P. 99, "Replacing the Wiper"

An Error Message Appears

This describes the error messages that may appear on the machine's display, and how to take action to remedy the problem. If the action described here does not correct the problem, or if an error message not described here appears, contact your authorized Roland DG Corp. dealer .

[TURN POWER OFF AND SET INK MODE]

The sub power is turned on with the ink mode unset.

Turn off the sub power. Select the ink mode, and then turn on the sub power.

☞ "Setup Guide"

[CAN'T PRINT CROP CONTINUE?]

The size of the data including the crop marks is larger than the printing or cutting area of the loaded media.

To continue performing output without correcting this, press (ENTER) . At this time, the portion extending beyond the printing or cutting area and the crop marks are not output. To stop output, stop sending data from the computer, then raise the loading lever. Make the printing or cutting area wider, such as by replacing the media with a larger piece of media or by changing the positions of the pinch rollers, then send the data again.

The size of the data being output is too small.

Make the scanning-direction (movement direction of print heads) size of the data at least 65 mm (2.6 in). To continue performing output without correcting this, press (ENTER) . At this time, the data is output without printing the crop marks. To stop output, stop sending data from the computer, then hold down (SET UP) for one second or longer. Change the size of the data, then send the data again. There is no limitation in the size of the data in the media-feed direction.

[TEMPERATURE IS TOO HIGH **°C]

The temperature of the location where the machine is installed has risen above the ambient temperature at which the machine can operate.

Operation cannot be continued. Switch off the sub power. The displayed temperature is the current ambient temperature of the installation location. Bring the installed location to a temperature at which operation is possible (20 to 32°C) and allow the machine to come to room temperature, then turn on the power.

[SERVICE CALL xxxx]

An unrecoverable error occurred, or part replacement that must be performed by a service technician is required.

Note the number displayed, then switch off the sub power. After you switch off the power, inform your authorized Roland DG Corp. dealer of the number that appeared on the display screen.

[SHEET SET ERROR SET AGAIN]

(SET UP) was pressed even though no media is loaded.

Press any key to clear the error. Load media and pull back the loading lever, then press (SET UP).

☞ P. 49, "Loading Media"

[SHEET TYPE] is set to "OPAQUE," but transparent media was loaded.

Flip the loading lever down to the rear, set the [SHEET TYPE] menu item to "CLEAR" then reload the media.

☞ P. 114, "Using Transparent or High Gloss Media"

The loaded media is too small.

Press any key to clear the error. Replace with media of usable size.

When [SHEET TYPE] is set to [OPAQUE] while using substrates with metallic or reflective characteristics, such as metallic film.

Move the loading lever to the rear, set [SHEET TYPE] to [CLEAR], and then set it again. When using substrates with metallic or reflective characteristics such as metallic film, light reflecting off the media prevents the machine from detecting the edge of the media. Therefore, treat these types of materials as transparent media when implementing settings.

[TEMPERATURE IS TOO LOW **°C]

The temperature of the location where the machine is installed has fallen below the ambient temperature at which the machine can operate.

Operation cannot be continued. Switch off the sub power. The displayed temperature is the current ambient temperature of the installation location. Bring the installed location to a temperature at which operation is possible (20 to 32°C) and allow the machine to come to room temperature, then turn on the power.

[DATA ERROR CANCELING...]

Output was stopped because a problem was found in the data received.

Operation cannot be continued. Check whether the data contains errors. Also, check for a problem with the connector cable or the computer, and redo the operation from the step of loading the media.

[PINCHROLL ERROR LOWER PINCHROLL]

(SET UP) was pressed without first lowering the pinch rollers.

Pull back the loading lever, then press (SET UP).

The pinch rollers are lifted up during output.

Output is discontinued. Do not move the loading lever during output.

[WRONG CARTRIDGE]

A cartridge that cannot be used was installed.

Remove the cartridge to clear the error. Use a cartridge of the specified type.

[WRONG HEAD IS INSTALLED]

Unusable print heads are installed.

Switch off the sub power. After you switch off the power, inform your authorized Roland DG Corp. dealer.

[AVOIDING DRY-UP TURN POWER OFF]

The print heads were forced to standby position to prevent them from drying out.
Operation cannot be continued. Switch the sub power off, then back on. Opening the front cover while output is in progress causes an emergency stop. Never allow the print heads to remain in this state.

[MOTOR ERROR TURN POWER OFF]

A motor error occurred.
Operation cannot be continued. Switch off the sub power. Next, eliminate the cause of the error, then immediately switch on the sub power. If the machine is allowed to stand with the error uncorrected, the print heads may dry out and become damaged. This error may be caused by such factors as a mistake in loading the media, a media jam, or an operation that pulls the media with excessive force.

The media has jammed.
Carefully remove the jammed media. The print heads may also be damaged. Perform cleaning of the print heads, then perform a printing test and check the results.

The media was pulled with excessive force.
Excessive tension was applied to the media, and additional action is necessary to recover from this state. First, move the loading lever to the rear and adjust the media to create a small amount of slack, then switch on the sub power.

[CANCELED FOR MOTOR PROTECTION]

Either of the following menu items is to be started in a row within 10 minutes:

- PUMP UP
- HEAD WASH
- INK RENEWAL
- POWERFUL CLEANING

Press any key other than the sub power switch to cancel the error message. Allow the machine to stand for approximately 10 minutes before resuming operation. These menu items require the pump motor to turn for a long time. When performing these menu items in a row, take an interval of at least 10 minutes to prevent damage to the machine due to the overheating of pump motor.
However, you may continuously start "POWERFUL CLEANING" without an interval of at least 10 minutes. Doing so will not cause the error message to appear.

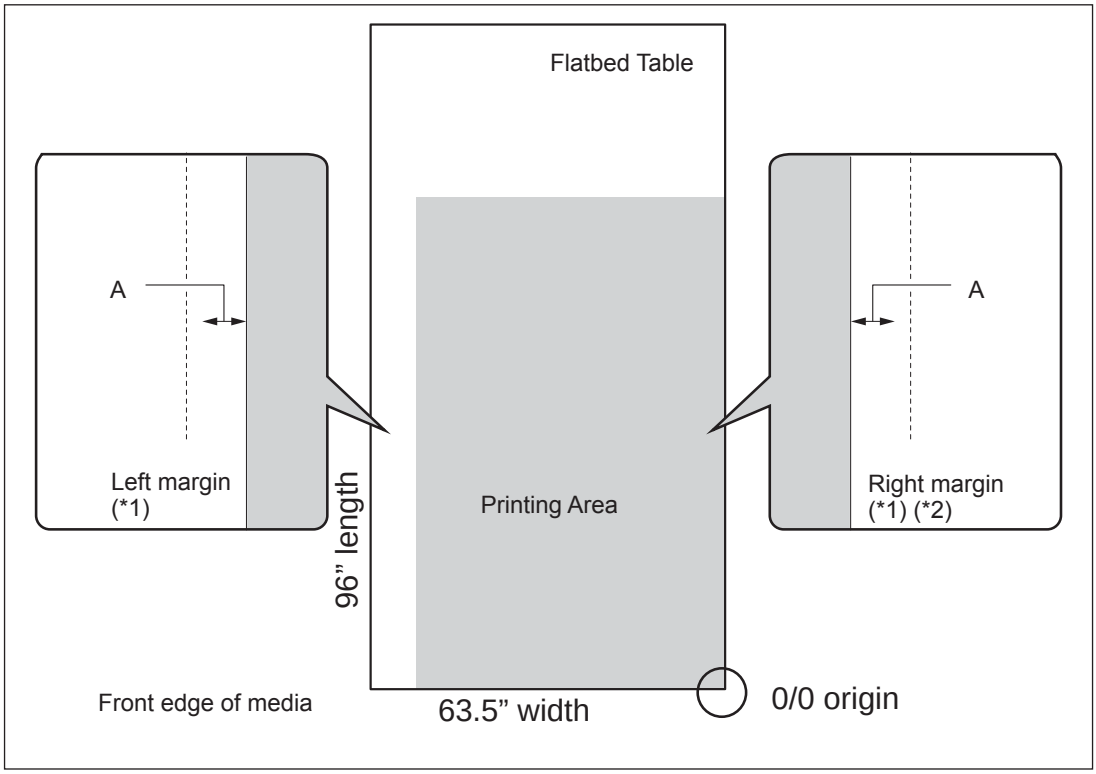
Chapter 8
Main Specifications

Printing Area 146
Printing Area and Margins 146
Maximum Area When Using Crop Marks 148

Locations of the Power Rating and Serial Number Labels 150
Specifications 151

Printing Area

Printing Area and Margins - Updated for Flatbed table



NOTE: Margins can NOT be overriden. The printing area of the flatbed table accomodates the 5mm.

A: Setting of the [SIDE MARGIN] menu item (5 mm (3/16 inch), 10mm (6/16 inch) (default setting), or 25 mm (16/16 inch))

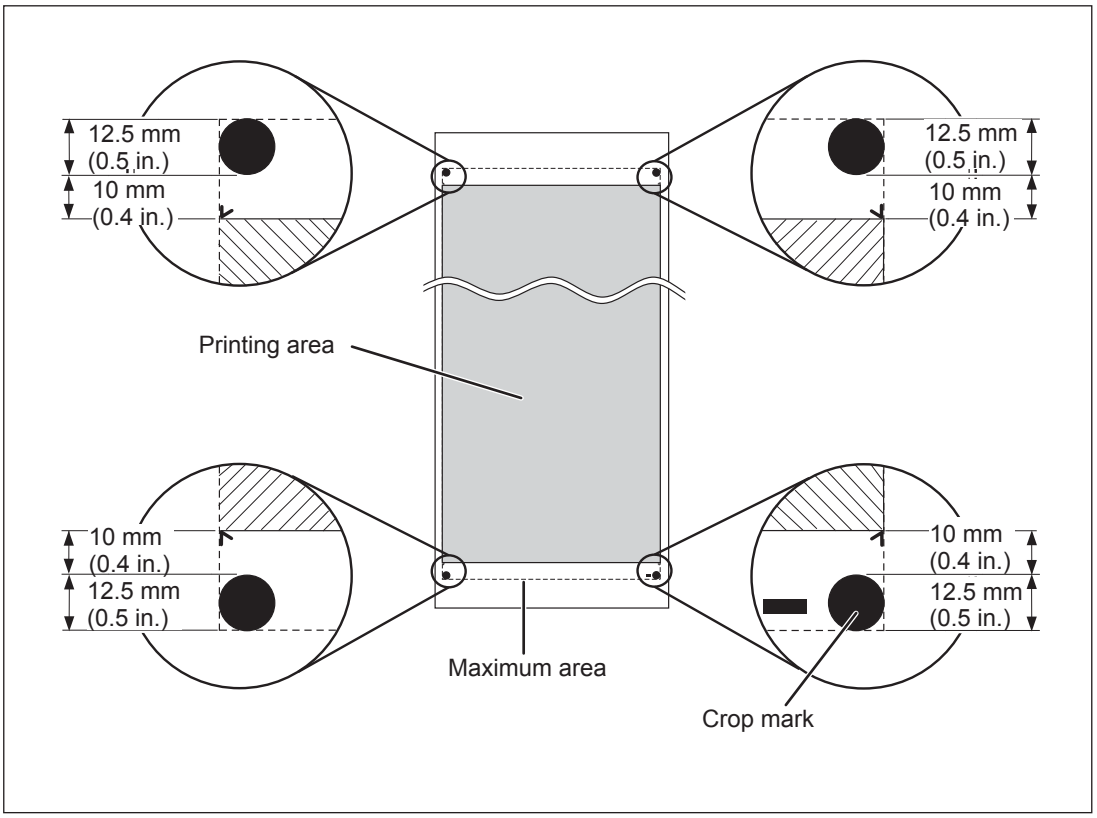
*1 The amount of the left and right margins is the total of A and B. In the following cases, however, the setting for A becomes the amount of margin without change.

➢ When the [SHEET TYPE] menu item is set to [CLEAR] is NO longer NEEDED!

*2 The amount of right margin can be changed by using (BASE POINT).

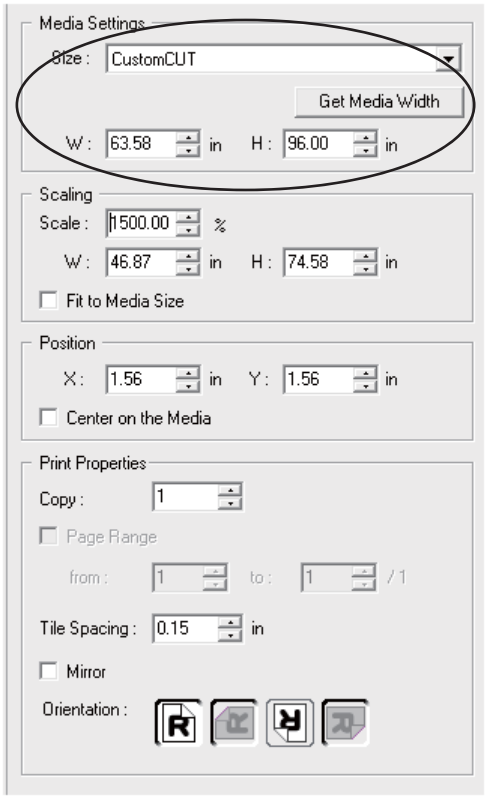
Maximum Area When Using Crop Marks

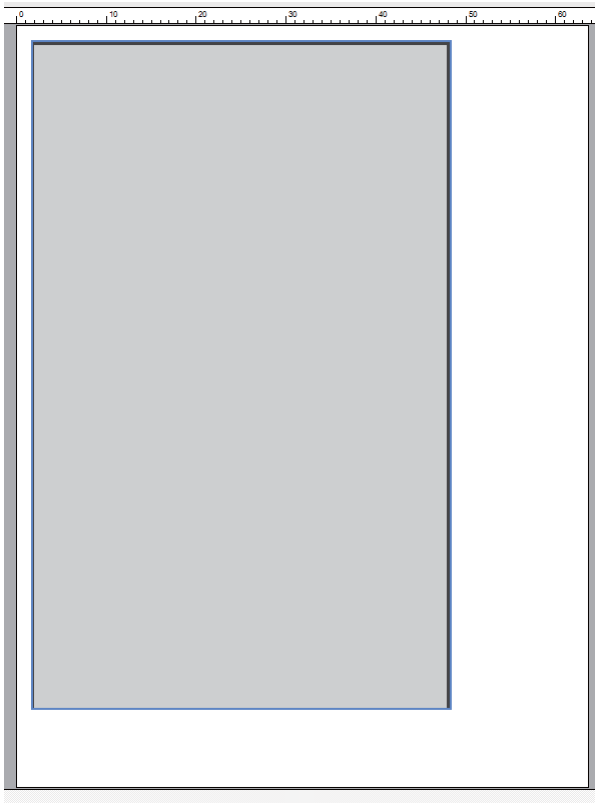
When crop marks are used, the printing area is reduced from the maximum area by an amount equal to the crop marks.



Maximum Area in VersaWorks

➢ In VersaWorks, set the Media Settings to CustomCUT to be used.

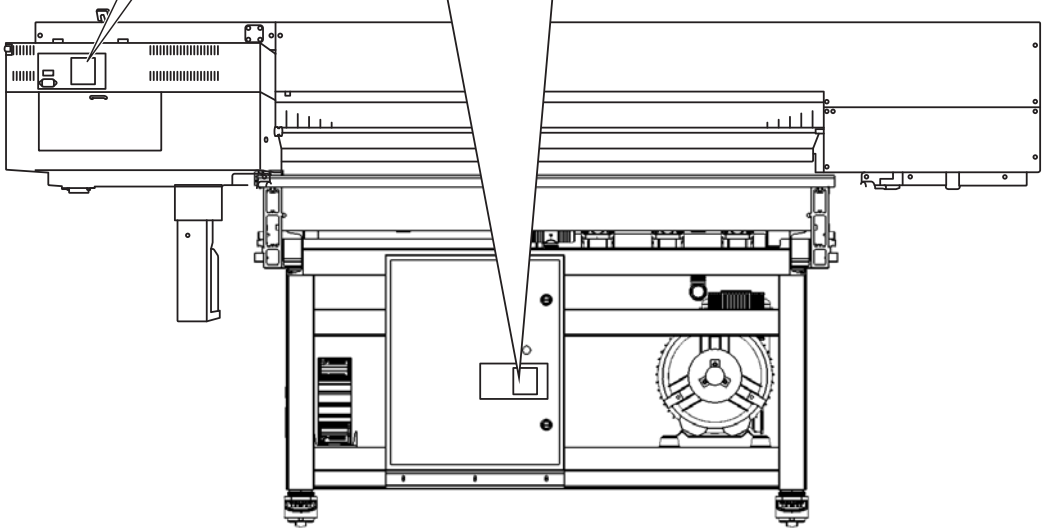




Locations of the Power Rating and Serial Number Labels

Serial Number
This is required when you seek maintenance, servicing, or support. Never peel off the label.

Power Rating
Use an electrical outlet that meets the requirements for voltage, frequency, and amperage given here.

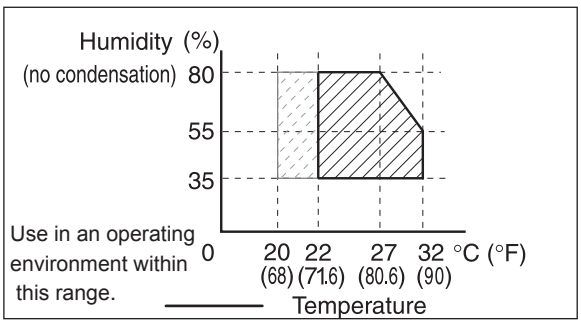


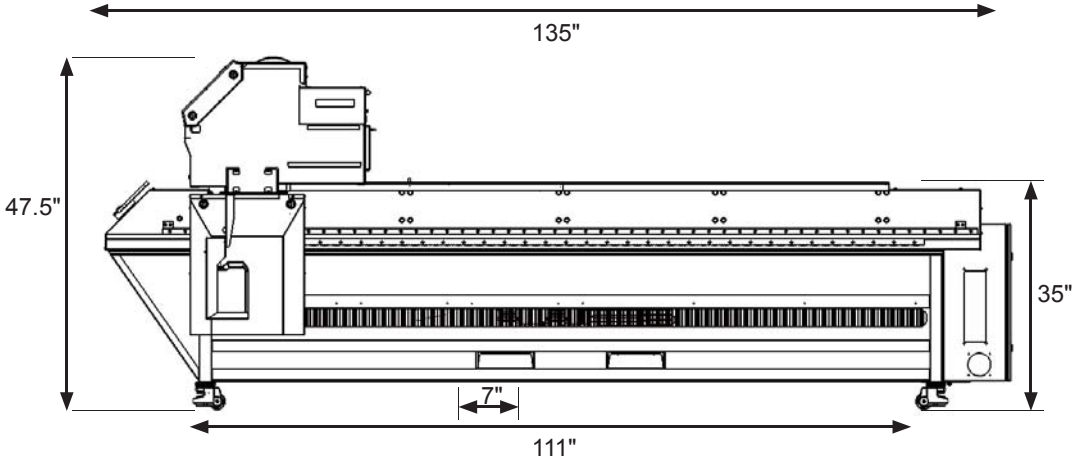
Specifications

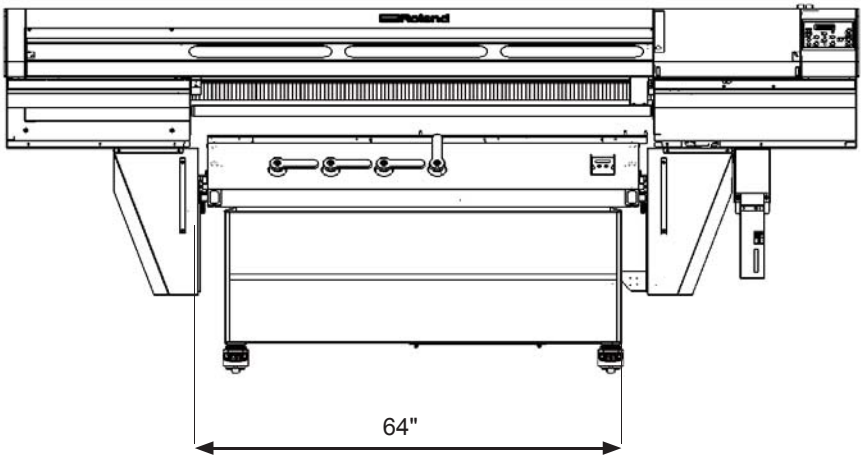
VersaUV® LEJ-640FT Specifications			
Printing method			Piezoelectric inkjet / Flatbed Table Absorption through use of a vacuum
MEDIA	Print Area	Flat Media or Cut Sheet	63” x 96” (1625 mm x 2502 mm)
	Thickness	Flat Media or Cut Sheet	6” (152 mm)
	Weight	Flat Media or Cut Sheet	220 lbs. (100 kg)
Ink System	Type		Roland ECO-UV or ECO-UV S ink
	Capacity		220 ml (± 5 ml)
	Colors		ECO-UV: 6 colors (Cyan, Magenta, Yellow, Black, White and Gloss) ECO-UVS: 5 colors (Cyan, Magenta, Yellow, Black and White)
	Configurations		ECO-UV: CMYK+Gloss+White, CMYK+White+White or CMYK+Gloss+Gloss ECO-UV S: CMYK+White+White
Ink curing unit	Dual Automatic UV LED Lamps		Dual UV LED Lamps
	Standard LED Service life		Up to 10,000 hours
Printing resolutions			360 x 720 dpi, 540x720 dpi, 720 x 1080 dpi, 720 x 1440 dpi, 1440 x 1440 dpi
Distance accuracy			Error of less than ± 0.3 % of distance traveled, or ± 0.012 in (0.3 mm), whichever is greater.
Media Absorption	Vacuum		Absorption fixed through use of a vacuum
	Number of absorption area partitions		4 partitions (2X-axis directions/2Y-axis directions)
Interface			Ethernet (10 BASE-T / 100 BASE-TX, automatic switching)
Power supply	Voltage and frequency		Single phase, 220 V AC, 50 Hz/60 Hz
	Required power capacity		30A Max
Power consumption			3.0 kVA Max
Environment	Dimensions		126[W] x 147[D] x 47.5[H] in (3200.4[W] x 3733.8[D] x 1206.5[H] mm)
	Weight		Printer unit: 503 lbs. (228.157 kg.) With table unit: 2,612 lbs. (1184.783 kg)
	Power on		Temperature: 68° to 90°F (20° to 32°C) (72°F [22°C] or more recommended), Humidity: 35% to 80% (no condensation)
	Power off		Temperature: 41° to 104°F (5° to 40°C), Humidity: 20 to 80% (no condensation)
Included items			Cleaning kit, Roland VersaWorks software RIP, User’s manual, etc.

(*1)

- Media type: Media specified by Roland DG Corp.
- Temperature: 25°C (77°F), humidity: 50%RH
- Excluding expansion/contraction of the media
- All correction or adjustment function of this machine has been made properly.
- With Roland PET film, print travel: 1 m




135"
47.5"
35"
7"
111"


64"